OS2 65
bilico | pivot

CATALOGO TECNICO
TECHNICAL CATALOGUE

METALFORM

Sistema integrato di profili, accessori e guarnizioni a taglio termico con profili aventi sezione in vista di 62 mm, dedicato alla realizzazione di serramenti con aperutra a bilico verticale e orizzontale

I profili in metallo componenti il sistema sono dello spessore di 15/10 mm e sono ottenuti tramite profilatura a freddo di nastri nei vari materiali previsti dal sistema.

Il taglio termico dei profili è realizzato tramite un estruso in poliammide rinforzato con fibra di vetro reso solidale alle parti in metallo esterne da una resina poliuretanica ad alta densità, iniettata ad alta pressione. Il collegamento che si ottiene è continuo, privo di interruzioni e garantisce la massima resistenza torsionale e flettente.

La costruzione dei telai prevede l'unione tra i profili tramite saldatura in continuo delle sezioni in contatto e la successiva ripresa delle superfici in vista, o l'utilizzo di un sistema misto ad assiemaggio meccanico a saldatura interna che non necessita di riprese di finitura.

Il sistema prevede al possibilità di alloggiare **vetri singoli o stratificati** (di sicurezza) a una o più camere.

Caratteristiche del sistema:
Sormonto interno ed esterno delle ante;
Sistema a 3 livelli di tenuta per apertura interna, con guarnizione di giunto aperto e guarnizione interna ed esterna di battuta per le migliori prestazioni di tenuta all'aria e all'acqua e di isolamento acustico;
Doppia guarnizione di battuta per l'apertura esterna;
Sistema integrato completo di accessori per lo scarico acqua nello stesso materiale del profilo;
Kit completo per l'apertura a bilico con ferramenta integrata al profilo;
Accessori di movimentazione negli stessi materiali del profilo.

System of thermally broken profiles, accessories and gaskets *with visible section of 62 mm suitable for vertical and horizontal pivoting windows.*

The metal profiles *that make up the system are 15/10 mm thick and are obtained from the cold-forming of the coils in the various materials available.*

The profile thermal break *is connected by means of a glass-fibre reinforced, extruded polyamide that becomes one with the external metal parts with the use of a high density polyurethane resin, injected at high pressure. The connection is continuous, without interruptions, guaranteeing maximum resilience to torsional and bending stress.*

The assembly of the frames *requires that the profiles be connected by welding together the sections in contact and then that the visible welds must be ground down neatly and finished, or by combining mechanical assembly and internal welding that does not require the retouching of the finish.*

The system permits to use double or triple thermal insulated glazing with ***single or stratified glass*** *(security glass).*

Features of the system:
Surmounted internal and external design of the sections ;
System with 3 barriers of tightness for inward opening, with central gasket and internal and external rebate gasket and for the best water and air tightness and acoustic performances;
Double rebate gasket for outwards opening leaf;
Integrated system complete of accessories for water drain in the material of profile;
Full set of accessories for vertical pivoting windows with integrated ironmongery;
Pivot bearing in the same material of profile.

PRESTAZIONI

Sistema
Trasmittanza termica (EN ISO 10077-2)
- Nodo tipo: U_f =3,10 W/m^{2}K

Bilico verticale
Resistenza all'aria (DIN EN 12207)
- Fino a Classe 4

Resistenza all'acqua (DIN EN 12208)
- Fino a Classe 6A

Resistenza al vento (DIN EN 12210)
- Fino a Classe C5

Prova di durata a cicli di apertura (DIN EN 1197-12400)
- Fino a Classe 2 - 10.000 cicli

Bilico orizzontale
Resistenza all'aria (DIN EN 12207)
- Fino a Classe 4

Resistenza all'acqua (DIN EN 12208)
- Fino a Classe 7A

Resistenza al vento (DIN EN 12210)
- Fino a Classe C3

PERFORMANCES

System
Thermal transmittance (EN ISO 10077-2)
- *Typical section: U_f =3,10 W/m^{2}K*

Vertical pivot
Air permeability (DIN EN 12207)
- *Up to Class 4*

Watertightness (DIN EN 12208)
- *Up to Class 6A*

Resistance to wind load (DIN EN 12210)
- *Up to Class C5*

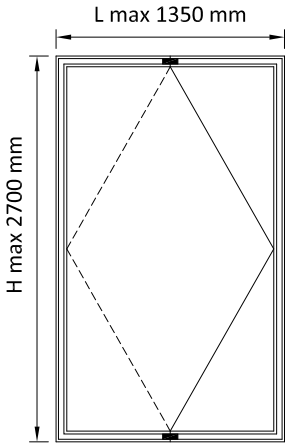
Resistance to repeated opening and closing (DIN EN 1197-12400)
- *Up to Class 2 - 10 000 opening and closing*

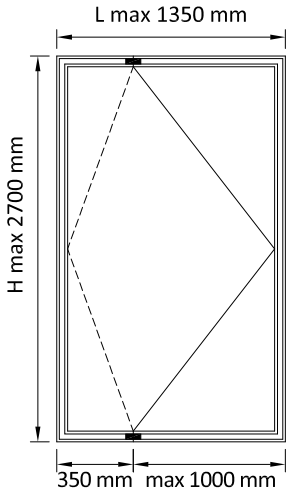
Horizontal pivot
Air permeability (DIN EN 12207)
- *Up to Class 4*

Watertightness (DIN EN 12208)
- *Up to Class 7A*

Resistance to wind load (DIN EN 12210)
- *Up to Class C3*

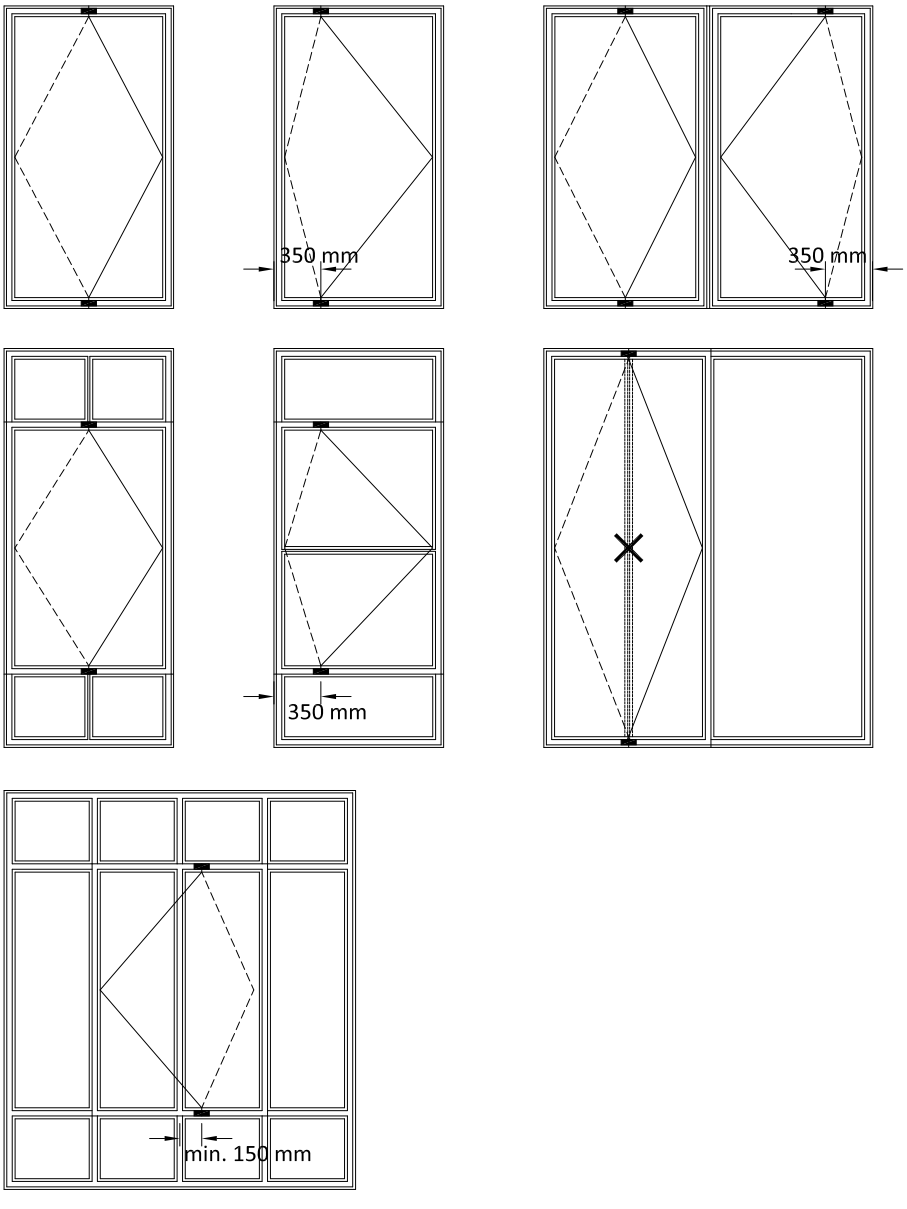
Limiti dimensionali - *Maximum dimension*



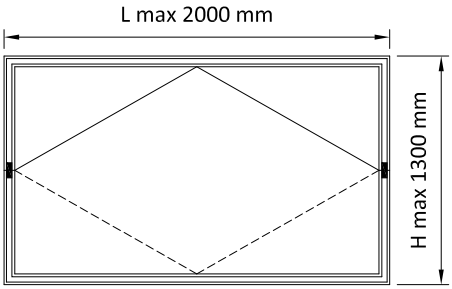


peso massimo anta 100 kg
maximum leaf weight 100 kg

Esempi tipologie realizzabili - *Types of windows*

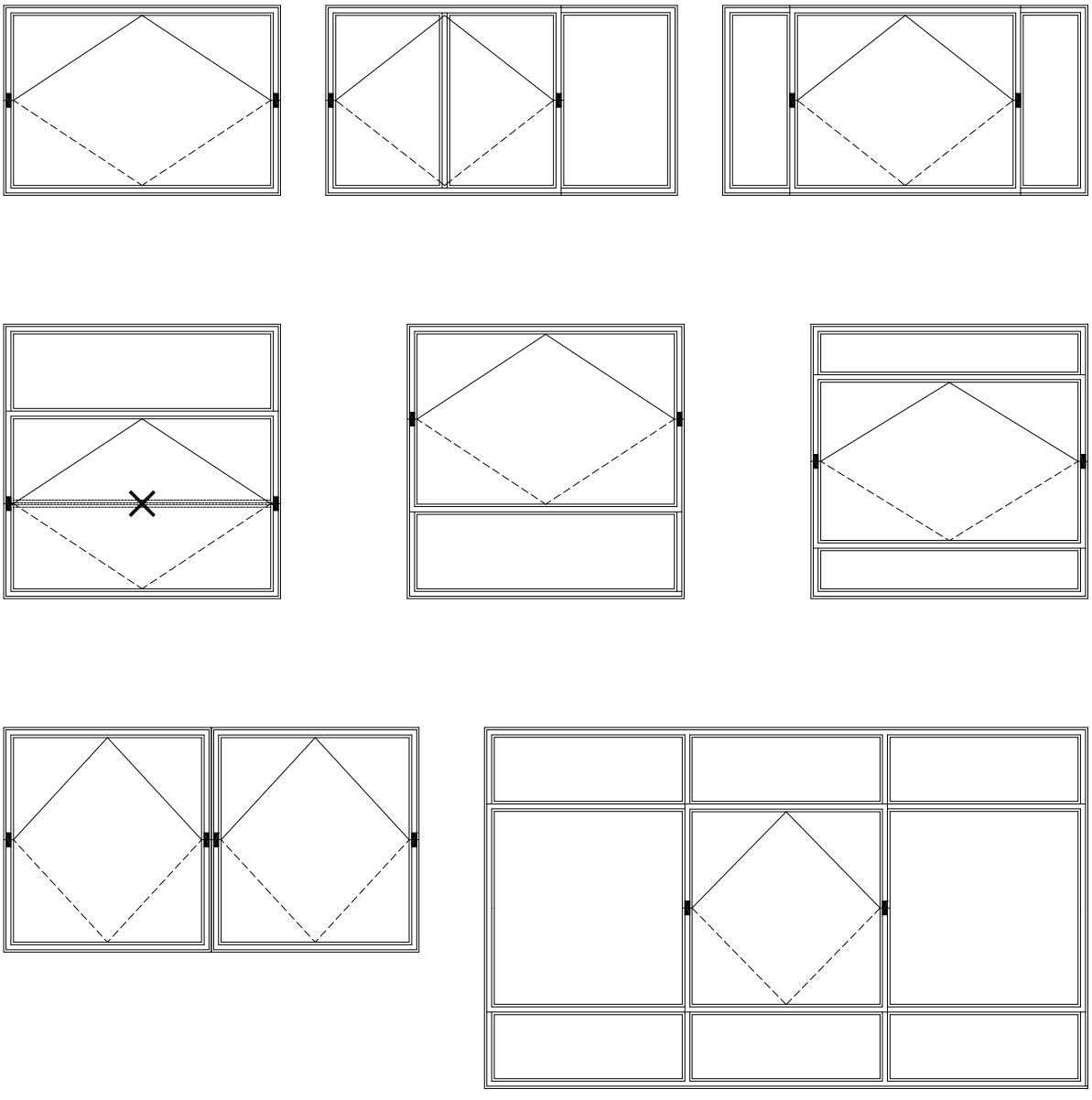


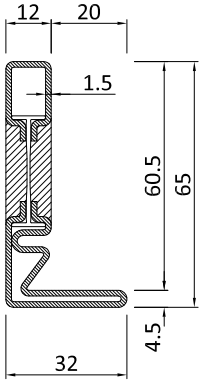
Limiti dimensionali - *Maximum dimension*



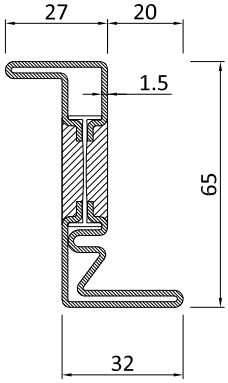
peso massimo anta 100 kg
maximum leaf weight 100 kg

Esempi tipologie realizzabili - *Types of windows*





PR2801



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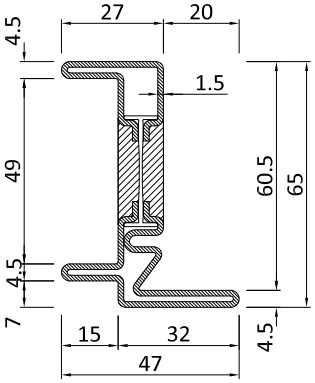

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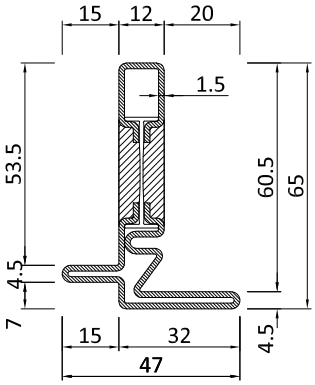

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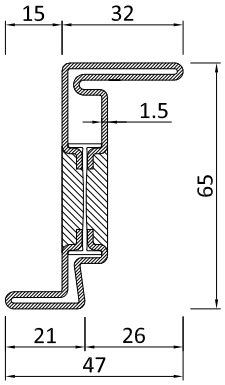

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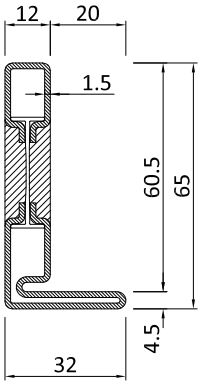

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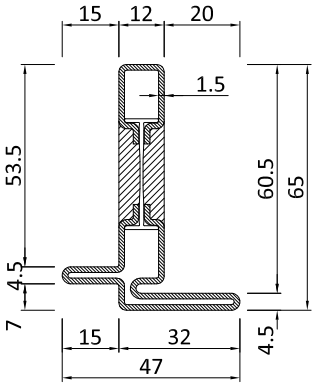

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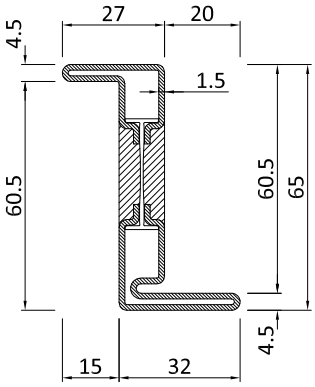

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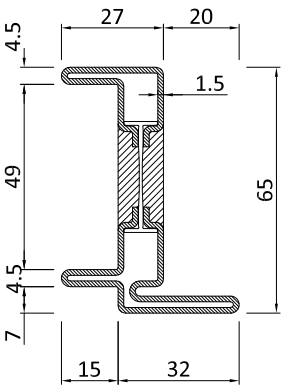
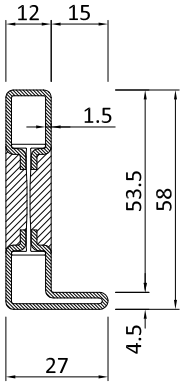


PR2865

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2801	2,37	2,54	0,22	11,33	1,78	6,0
PR2803	2,71	2,91	0,24	15,05	2,80	6,0
PR2815	2,99	3,22	0,27	15,83	3,70	6,0
PR2842	2,65	2,85	0,24	11,80	2,86	6,0
PR2843	2,63	2,80	0,24	14,70	2,72	6,0

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2861	2,30	2,46	0,21	11,45	1,74	6,0
PR2862	2,57	2,76	0,24	11,90	2,97	6,0
PR2863	2,64	2,83	0,24	15,19	2,79	6,0
PR2865	2,95	3,13	0,26	15,96	3,82	6,0



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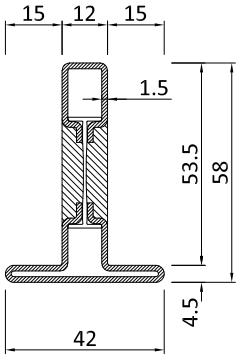

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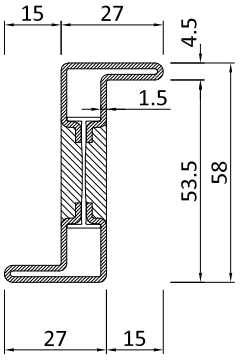

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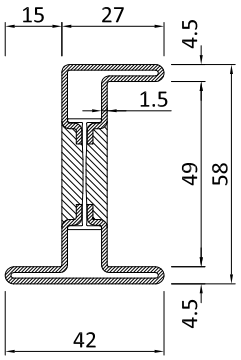

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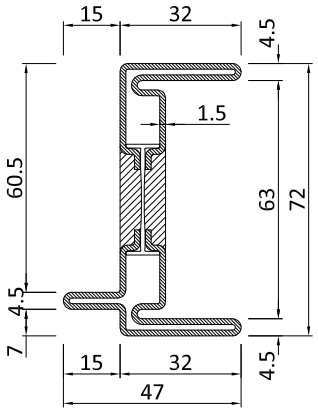
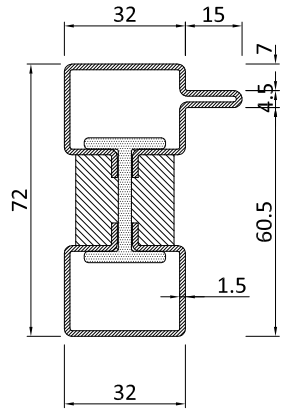


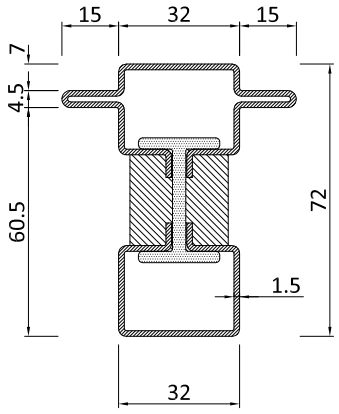
PR2875

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2871	1,85	1,98	0,17	7,82	1,02	6,0
PR2872	2,18	2,34	0,20	9,00	2,12	6,0
PR2873	2,19	2,35	0,20	10,44	3,32	6,0
PR2874	2,52	2,71	0,23	12,17	2,87	6,0
PR2875	3,30	3,61	0,30	22,81	4,36	6,0

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m



PR2891



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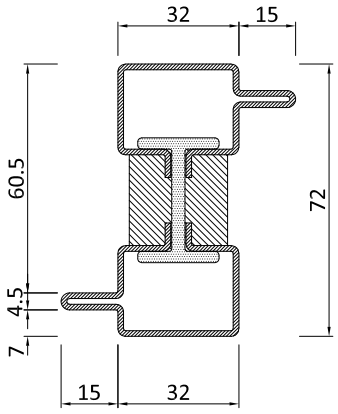

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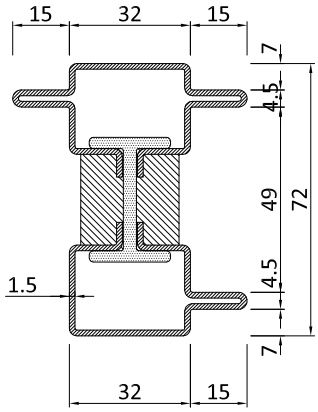

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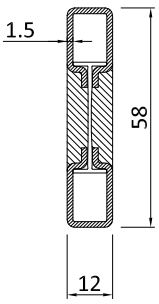

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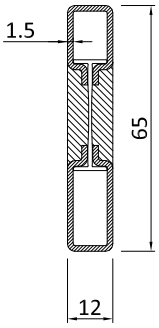

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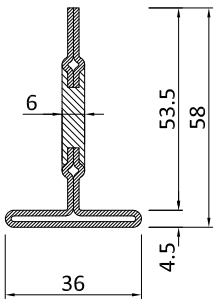

PR2664

Non fornito in Inox
Not in Inox

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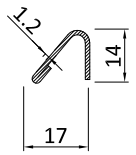
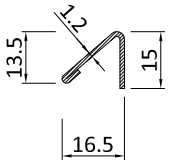
PR2891	4,14	4,41	0,23	13,58	6,59	3,0
PR2892	4,22	4,50	0,25	14,44	9,44	3,0
PR2893	4,29	4,58	0,25	14,93	10,56	3,0
PR2895	4,60	4,91	0,28	15,96	11,62	3,0
PR2830	1,51	1,61	0,14	8,16	0,30	6,0

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2831	1,68	1,79	0,16	7,95	0,36	6,0
PR2664	2,28	2,47	0,19	9,23	1,20	6,0



PR2620



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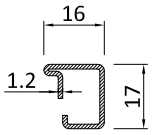

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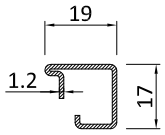

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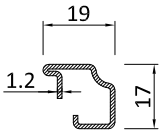

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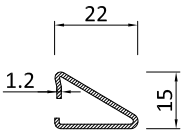

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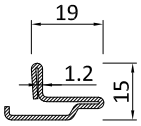

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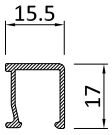

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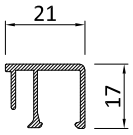

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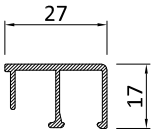


PA2608

MATERIALE | *MATERIAL*

PR _ _ _ _ ZN acciaio zincato | *galvanized steel*

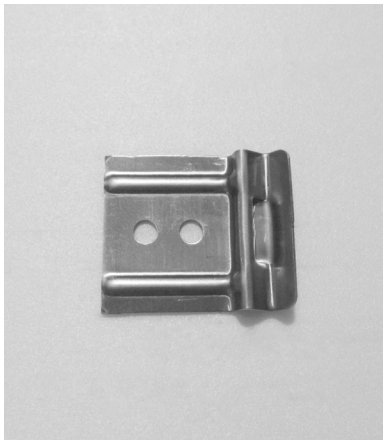
PR _ _ _ _ CZ acciaio corten grezzo | *untreated corteen steel*

PR _ _ _ _ SB acciaio inox scotch brite | *stainless steel scotch brite*

PR _ _ _ _ BR ottone grezzo | untreated brass

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PR2620	0,24	0,27				4,0
PR2670	0,40	0,43				4,0
PR2606	0,48	0,52				6,0
PR2607	0,51	0,55				6,0
PR2627	0,47	0,51				6,0
PR2629	0,49	0,53				6,0
PR2638	0,60	0,65				6,0

Profilo / Profile n°	P Kg/m ZN / I - CT	P Kg/m OT	A m^2/m	Jx cm^4	Jy cm^4	L m
PA2606	0,17	Alluminio				6,0
PA2607	0,23	Alluminio				6,0
PA2608	0,26	Aluminio				6,0



AC 2608

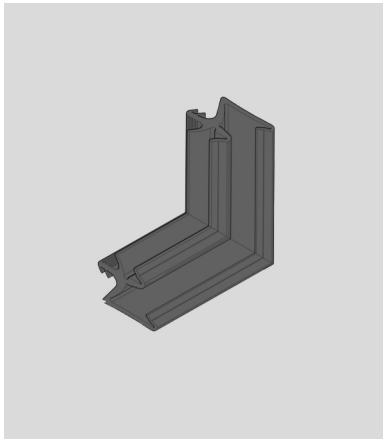
Clips per fissaggio fermavetri
PR2606 - PR2607 - PR2627
PR2629 - PR2638

Clips for securing
PR2606 - PR2607 - PR2627
PR2629 - PR2638
glazing beads

AC 2609

Clips per fissaggio fermavetri
su profilo PR2654 - PR2664

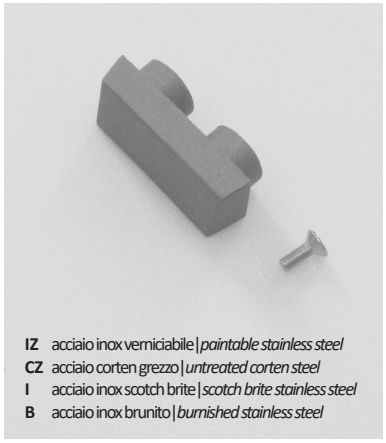
Clips for securing glazing beads
on PR2654 - PR2664 profile



AC 2617N

Guarnizione d'angolo
vulcanizzata per GE 2603

Vulcanised corner gasket
for GE 2603



IZ acciaio inox verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
I acciaio inox scotch brite | *scotch brite stainless steel*
B acciaio inox brunito | *burnished stainless steel*

AC 2618

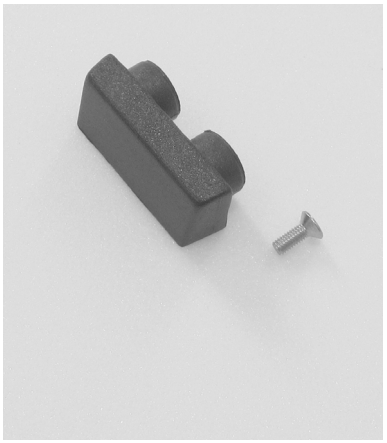
Scarico acqua per aperture
interne in metallo

Metal drip for inward openings

ACB 219.BR

Scarico acqua per aperture
interne in ottone naturale

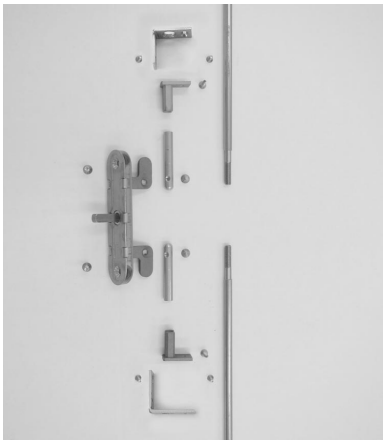
Natural brass drip for inward
openings



AC 2618NE

Scarico acqua per aperture
interne in plastica nera
Non verniciabile

Black plastic drip for inward
openings
Non paintable



AC 2625D

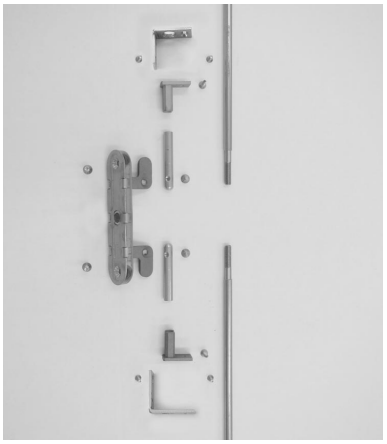
Kit cremonese dx per apertura
interna bilico verticale

RH cremone bolt set for vertical
pivot inward opening

AC 2625S

Kit cremonese sx per apertura
interna bilico verticale

LH cremone bolt set for vertical
pivot inward opening



AC 2625E D

Kit cremonese dx per apertura
interna bilico verticale
Gratz con maniglia removibile
RH cremone bolt set for vertical
pivot inward opening
Gratz mechanism with removable handle

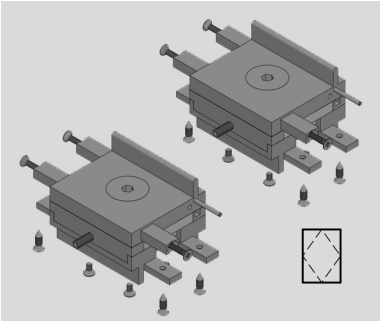
AC 2625E S

Kit cremonese sx per apertura
interna bilico verticale
Gratz con maniglia removibile
LH cremone bolt set for vertical
pivot inward opening
Gratz mechanism with removable handle

AC 2626R

Punto di chiusura aggiuntivo
per finestra

Additional locking point
for windows

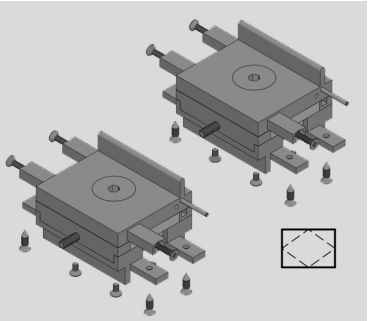


ZN acciaio zincato | *galvanized steel*
CZ acciaio corten grezzo | *untreated corten steel*
IZ acciaio inox grezzo | *untreated stainless steel*
BR ottone naturale | *natural brass*

AC 2633V.

Coppia cerniere per bilico verticale senza sopraluce superiore o sottoluce inferiore
Telaio PR2815|PR2865

Couple hinges for vertical pivot without top light or bottom light
Frame PR2815|PR2865

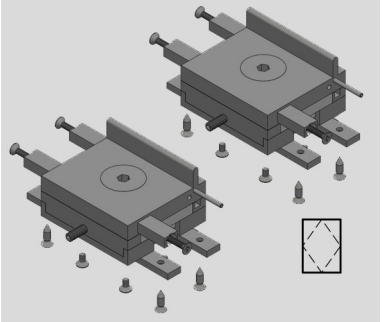


ZN acciaio zincato | *galvanized steel*
CZ acciaio corten grezzo | *untreated corten steel*
IZ acciaio inox grezzo | *untreated stainless steel*
BR ottone naturale | *natural brass*

AC 2633H.

Coppia cerniere per bilico orizzontale senza laterali fissi
Telaio PR2815|PR2865

Couple hinges for orizontal pivot without side light
Frame PR2815|PR2865

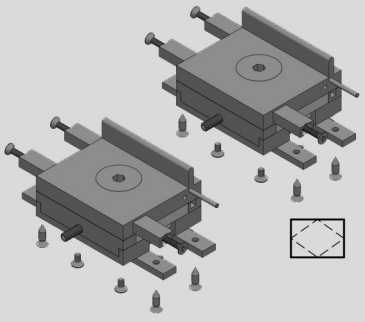


ZN acciaio zincato | *galvanized steel*
CZ acciaio corten grezzo | *untreated corten steel*
IZ acciaio inox grezzo | *untreated stainless steel*
BR ottone naturale | *natural brass*

AC 2633SV.

Coppia cerniere per bilico verticale senza sopraluce superiore o sottoluce inferiore
Telaio PR2801|PR2861

Couple hinges for vertical pivot without top light or bottom light
Frame PR2801|PR2861

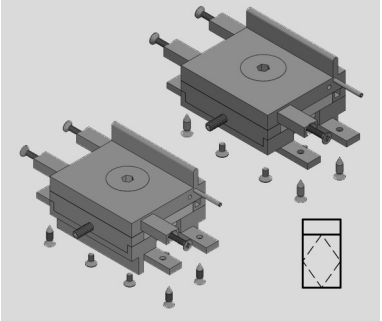


ZN acciaio zincato | *galvanized steel*
CZ acciaio corten grezzo | *untreated corten steel*
IZ acciaio inox grezzo | *untreated stainless steel*
BR ottone naturale | *natural brass*

AC 2633SH.

Coppia cerniere per bilico orizzontale senza laterali fissi
Telaio PR2801|PR2861

Couple hinges for orizontal pivot without side light
Frame PR2801|PR2861

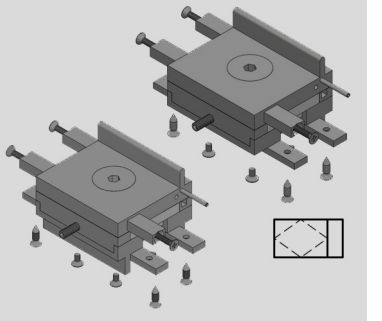


ZN acciaio zincato | *galvanized steel*
CZ acciaio corten grezzo | *untreated corten steel*
IZ acciaio inox grezzo | *untreated stainless steel*
BR ottone naturale | *natural brass*

AC 2637V.

Coppia cerniere per bilico verticale con sopraluce superiore o sottoluce inferiore

Couple hinges for vertical pivot with top light or bottom light

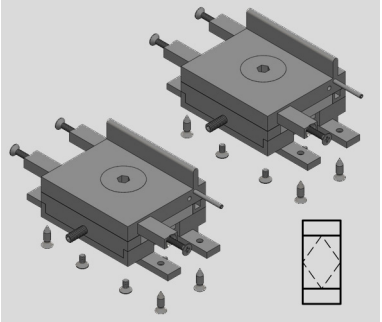


ZN acciaio zincato | *galvanized steel*
CZ acciaio corten grezzo | *untreated corten steel*
IZ acciaio inox grezzo | *untreated stainless steel*
BR ottone naturale | *natural brass*

AC 2637H.

Coppia cerniere per bilico orizzontale con un laterale fisso

Couple hinges for orizontal pivot with one side light

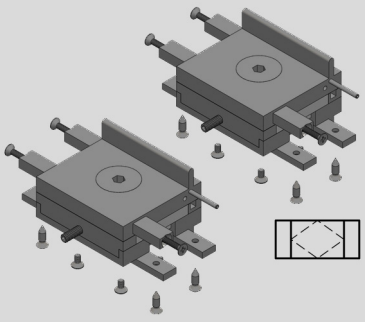


ZN acciaio zincato | *galvanized steel*
CZ acciaio corten grezzo | *untreated corten steel*
IZ acciaio inox grezzo | *untreated stainless steel*
BR ottone naturale | *natural brass*

AC 2638V.

Coppia cerniere per bilico verticale con sopraluce superiore e sottoluce inferiore

Couple hinges for vertical pivot with top light and bottom light



ZN acciaio zincato | *galvanized steel*
CZ acciaio corten grezzo | *untreated corten steel*
IZ acciaio inox grezzo | *untreated stainless steel*
BR ottone naturale | *natural brass*

AC 2638H.

Coppia cerniere per bilico orizzontale con due laterali fissi

Couple hinges for orizontal pivot with two side light

GZ acciaio zincato|*galvanized steel*
CZ acciaio corten|*corten steel*
I acciaio inox|*stainless steel*
B ottone naturale|*natural brass*

AC 2658

Fondino per profili
PR2875 | PR2891 | PR2892
PR2893 | PR2895
(apertura interna)

Fittings for profiles
PR2875 | PR2891 | PR2892
PR2893 | PR2895
(inward opening)

GZ acciaio zincato|*galvanized steel*
CZ acciaio corten|*corten steel*
I acciaio inox|*stainless steel*
B ottone naturale|*natural brass*

AC 2659

Fondino per profili
PR2875 | PR2891 | PR2892
PR2893 | PR2895
(apertura esterna)

Fittings for profiles
PR2875 | PR2891 | PR2892
PR2893 | PR2895
(outward opening)

AC 2683D

Kit cremonese dx per apertura esterna bilico verticale

RH cremone bolt set for vertical pivot outward opening

AC 2683S

Kit cremonese sx per apertura esterna bilico verticale

LH cremone bolt set for vertical pivot outward opening

AC 2683E D

Kit cremonese dx per apertura esterna bilico verticale
Gratz con maniglia removibile
RH cremone bolt set for vertical pivot outward opening
Gratz mechanism with removable handle

AC 2683E S

Kit cremonese sx per apertura esterna bilico verticale
Gratz con maniglia removibile
LH cremone bolt set for vertical pivot outward opening
Gratz mechanism with removable handle

AC 2686

Braccetto limitatore di apertura senza blocco

Window restrictor

CV1023 acciaio zincato|*galvanized steel*
CV1023I acciaio inox|*stainless steel*

CV 1023.

Vite per boccola fermavetri in alluminio, TPS 4.2x13

Screw for alluminium glazing bead bushing, TPS 4.2x13

CV1243 acciaio zincato|*galvanized steel*
CV1243I acciaio inox|*stainless steel*

CV 1243.

Vite trilobata per boccola fermavetri in alluminio, TPS M4x8

Thread cutting machine screw for alluminium glazing bead bushing, TPS M4x8

CV5012 acciaio zincato|*galvanized steel*
CV5012I acciaio inox|*stainless steel*

CV 5012.

Boccola per fermavetri in alluminio

Bushing for alluminium glazing bead

AC 2801I

Kit squadrette allineamento

Alignment bracket set

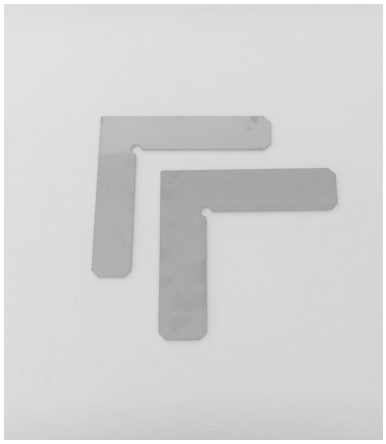
Profili | *Profiles*
PR2801 | PR2801 - PR2822
PR2801 - PR2803 | PR2801 - PR2805
PR2803 - PR2822 | PR2801 - PR2842
PR2803 - PR2842 | PR2805 - PR2842
PR2842 | PR2815 - P2842

AC 2855I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2855
PR2874



AC 2803I

Kit squadrette allineamento

Alignment bracket set

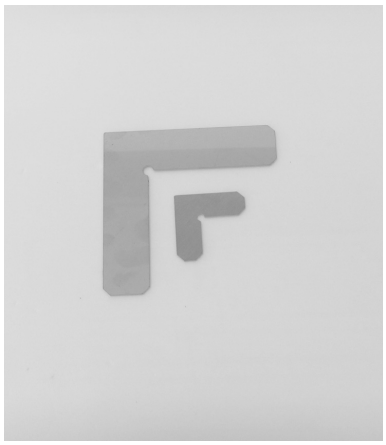
Profili | *Profiles*
PR2803
PR2815
PR2863
PR2865 - PR2863

AC 2862I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2862



AC 2843I

Kit squadrette allineamento

Alignment bracket set

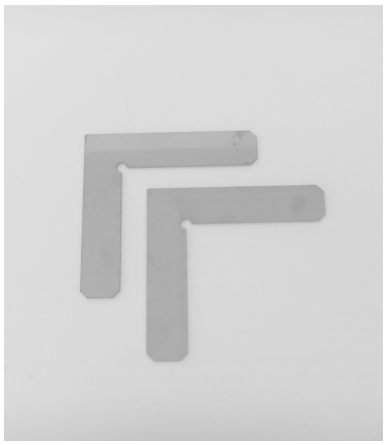
Profili | *Profiles*
PR2843

AC 2865I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2865



AC 2853I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2853
PR2873

AC 2871I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2871

AC 2872I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2872

AC 2895I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2895

AC 2875I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2875

AC 2891I

Kit squadrette allineamento

Alignment bracket set

Profili | *Profiles*
PR2891

AC 2892I

Kit squadrette allineamento

Alignment bracket set

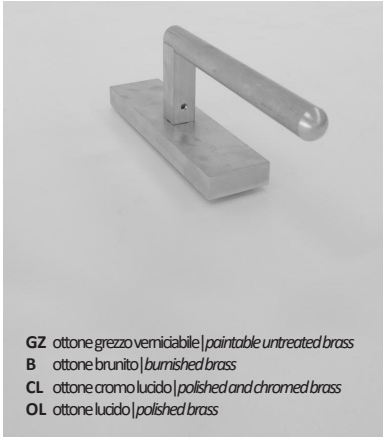
Profili | *Profiles*
PR2892
PR2893

GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 673

Copertina per gratz con maniglia removibile su kit
AC2624E | AC2625E
AC2683E | AC2684E

Cover for gratz mechanism on kit
AC2624E | AC2625E
AC2683E | AC2684E

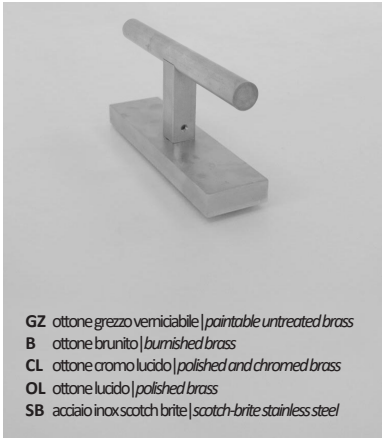


GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 774

Martellina cremonese
”VITRUVIO” small
per finestra
L | tonda| sfera

Cremone handle
small ”VITRUVIO”
for window
L | sphere | round



GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 771

Martellina cremonese
”VITRUVIO” small
per finestra
T | tonda| tronca

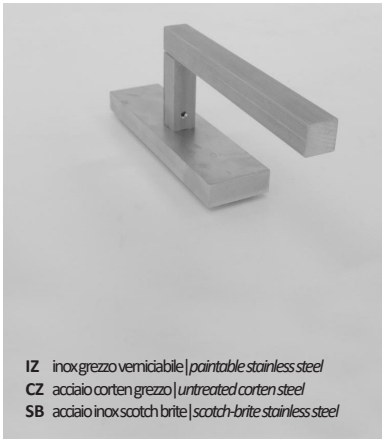
Cremone handle
small ”VITRUVIO”
for window
T | cut | round

GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 776

Martellina cremonese
”VITRUVIO”
per finestra
KIDS

Cremone handle
small ”VITRUVIO”
for window
KIDS



IZ inox grezzo verniciabile | *paintable stainless steel*
CZ acciaio corten grezzo | *untreated corten steel*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 772

Martellina cremonese
”VITRUVIO” small
per finestra
L | quadra | tronca

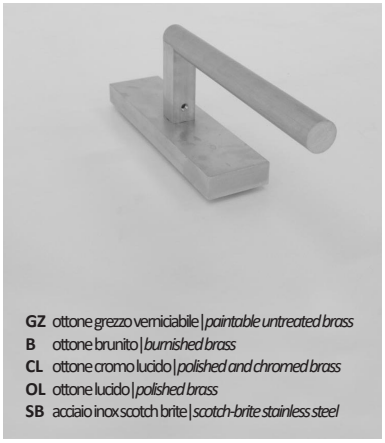
Cremone handle
small ”VITRUVIO”
for window
L | cut | square

GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 777

Martellina cremonese
”VITRUVIO”
per finestra
OVALE

Cremone handle
small ”VITRUVIO”
for window
OVAL



GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*
SB acciaio inox scotch brite | *scotch-brite stainless steel*

ACV 773

Martellina cremonese
”VITRUVIO” small
per finestra
L | tonda| tronca

Cremone handle
small ”VITRUVIO”
for window
L | cut | round

GZ ottone grezzo verniciabile | *paintable untreated brass*
B ottone brunito | *burnished brass*
CL ottone cromo lucido | *polished and chromed brass*
OL ottone lucido | *polished brass*

ACV 779

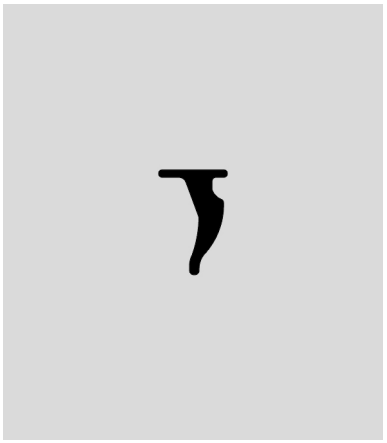
Martellina cremonese
”VITRUVIO” small
per finestra
T | tonda| sfera

Cremone handle
small ”VITRUVIO”
for window
T | sphere | round

GE 1011

Guarnizione interna vetro
spessore 4 mm

Internal weather strip for glazing bead
4 mm thick



GP 0095

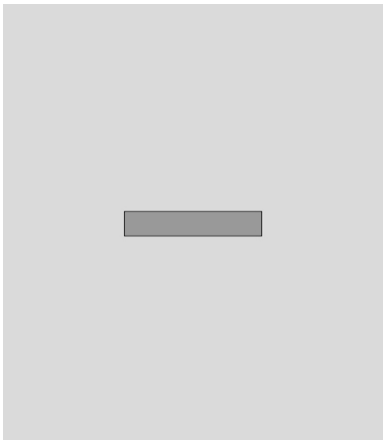
Guarnizione interna vetro
spessore 3mm

Internal weather strip for glazing bead
3 mm thick

GE 2603

Guarnizione per giunto aperto
Apertura interna

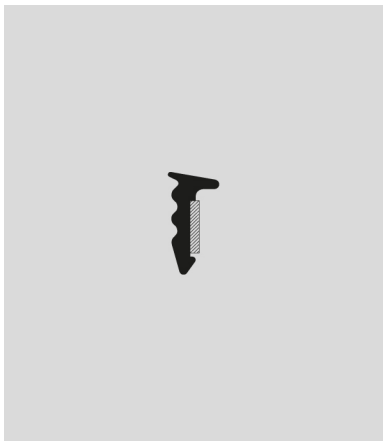
Weather strip for open joint
Inward opening



GU 2036

Piattina adesiva morbida
per fondo giunto esterno vetro
12x4 mm

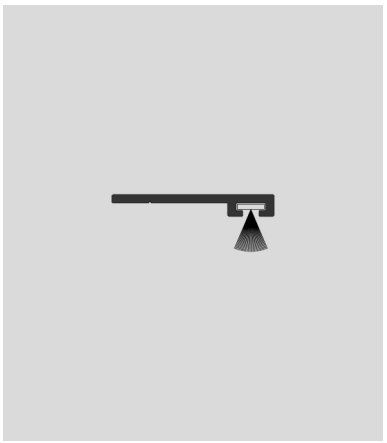
Soft adhesive shim for external window joint
12x4 mm



GE 2606

Guarnizione adesiva esterno vetro
vedi pg. 5.1.1

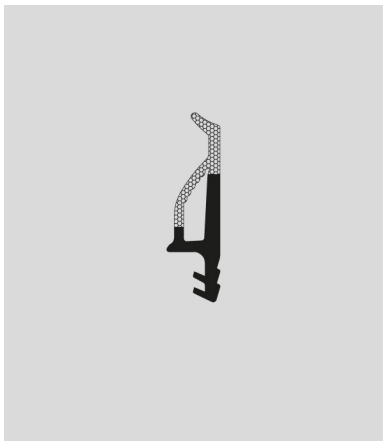
Adhesive weather strip outer window
see pg. 5.1.2



GU 2865

Spazzolino superiore per
apertura esterna

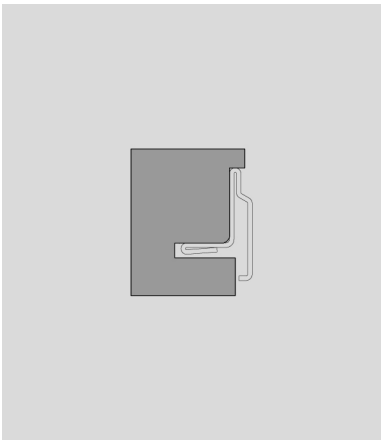
Upper brush window seal for outward opening



GE 2645TT

Guarnizione di battuta
interna|esterna su profili
PR2843 | PR2863 | PR2862

Internal/external weather strip with
PR2843 | PR2862 | PR2863 profiles



AT 2038

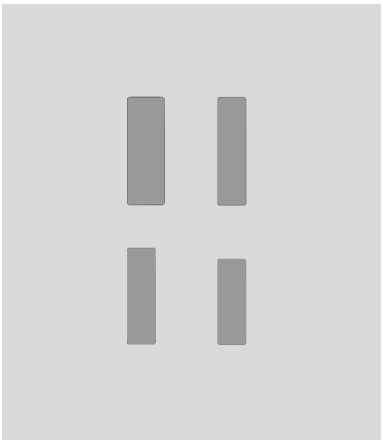
Ganasce di taglio per
PR2638

Cutting jaws for
PR2638

AT 2828

Maschera per esecuzione fori
fissaggio fermavetri

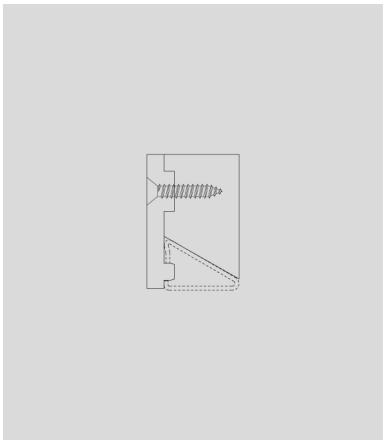
Drill jig for glazing beads
securing



AT 2800

Kit ganasce di taglio

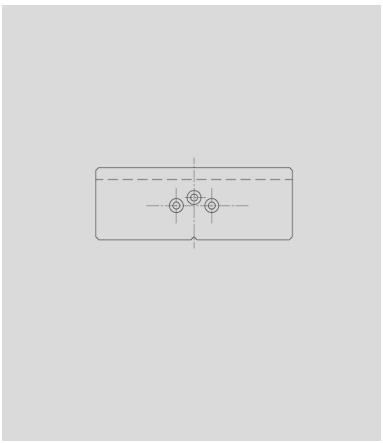
Kit of cutting jaws for profiles



AT 2829

Ganasce di taglio per
fermavetro PR2629

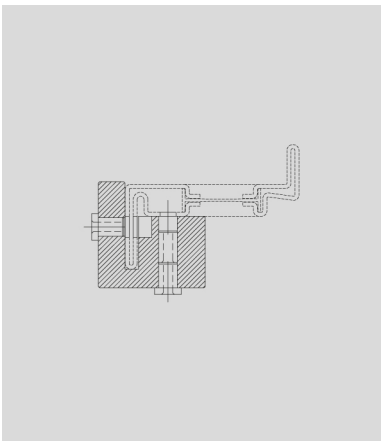
Kit of cutting jaws
for glazin bead PR2629



AT 2818

Maschera per esecuzione fori
per applicazione scarico acqua
AC2618 - AC2618NE

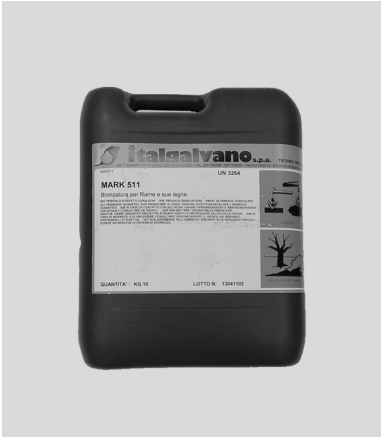
Drill jig for AC2618 - AC2618NE
water drip installation



AT 2825

Maschera per applicazione
cremonese AC2625 e AC2683

Jig for AC2625 and AC2683
cremone bolt installation



SA 0005.01

Liquido neritore per brunitura
1 Kg

Burnishing liquid
1 Kg

SA 0005.10

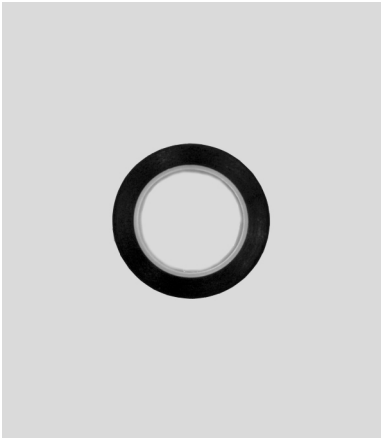
Liquido neritore per brunitura
10 Kg

Burnishing liquid
10 Kg

SA 2031

Liquido deumidificante vetri

Glass dehumidifying liquid



SA 1024

Nastro adesivo protettivo per verniciatura
24 mm

Adhesive tape for painting
24 mm

SA 2032

Primer di adesione per profili verniciati

Adhesion primer for painted profiles

SA 2001

Spray detergente antimpronta per superfici in acciaio inox

Anti-fingerprint detergent spray for stainless steel surfaces

SA 2033

Liquido di adesione per materiale plastico

Adhesion liquid for plastic

SA 2002

Spray solvente per rimozione collanti su superfici in acciaio inox

Solvent adhesive remover spray for stainless steel surfaces

SA 3001

Acido per ossidazione corten

Oxidising acid for corten

SA 3002.25

Passivante per ossidazione corten
25 Kg

Passivating agent for corten
25 Kg

SA 3002.05

Passivante per ossidazione corten
5 Kg

Passivating agent for corten
5 Kg

SA 3003

Cera d'api per finitura corten

Beeswax for Corten finishing

SL 0019

Sigillante a freddo per giunzione angoli e traversi

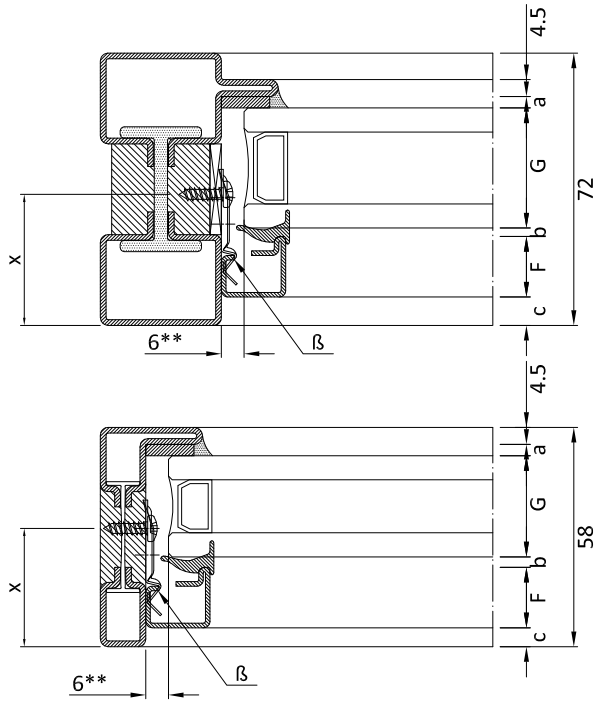
Cold sealant for corner and transom joints

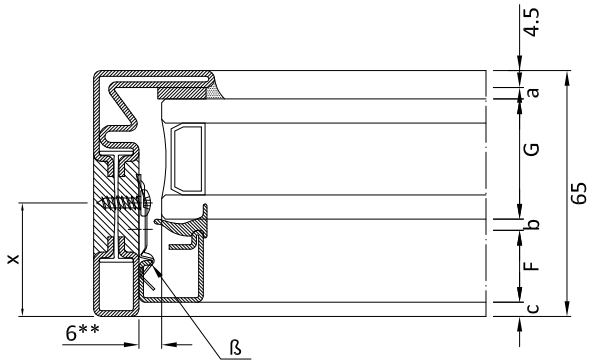
1 kg

SL 0021

Silicone nero per guarnizioni

Black silicone for gaskets

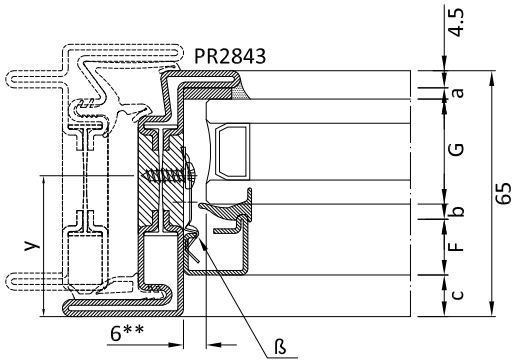


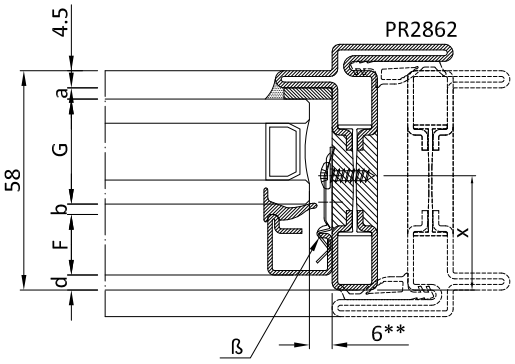


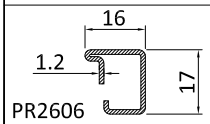
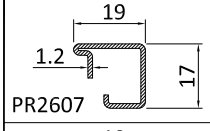
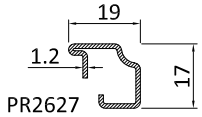
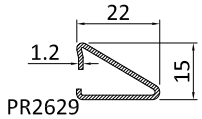
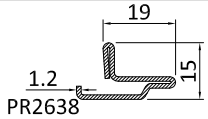
F	G			Guarnizioni - *gasket*									
fermavetro *glazing beads*	spessore vetro *glass thickness*			GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*			rientro fermavetro *glazing beads gap*			clips fissaggio fermavetro *glazing beads securing clips*
	mm					x			c			
codice *code*	Fisso 72 *Fix 72*	Fisso 65 *Fix 65*	Fisso 58 *Fix 58*	a	b	Fisso 72 *Fix 72*	Fisso 65 *Fix 65*	Fisso 58 *Fix 58*	Fisso 72 *Fix 72*	Fisso 65 *Fix 65*	Fisso 58 *Fix 58*	ß
16 / 1.2 / 17 PR2606	24 - 39	24 - 39	24 - 32	3	3	34 * - 26	34 * - 26	27 * - 26	15 - 0	15 - 0	8 - 0	AC2608
19 / 1.2 / 17 PR2607	24 - 36	24 - 36	24 - 29			31 * - 26	31 * - 26	24 * - 26	12 - 0	12 - 0	5 - 0	AC2608
19 / 1.2 / 17 PR2627	24 - 36	24 - 36	24 - 29			31 * - 26	31 * - 26	24 * - 26	12 - 0	12 - 0	5 - 0	AC2608
22 / 1.2 / 15 PR2629	24 - 33	28 - 33	24 - 25			39 * - 37	35 * - 30 *	32 * - 30 *	9 - 0	5 - 0	2 - 0	AC2608
19 / 1.2 / 15 PR2638	24 - 35	31 - 35	24 - 28			45 * - 34 *	38 * - 34 *	45 - 34 *	11 - 0	2 - 0	4 - 0	AC2608

** 7 mm per PR2638
** *7 mm for PR2638*

* fissare tramite il primo foro della clip
* *screw in the upper hole of the clip*

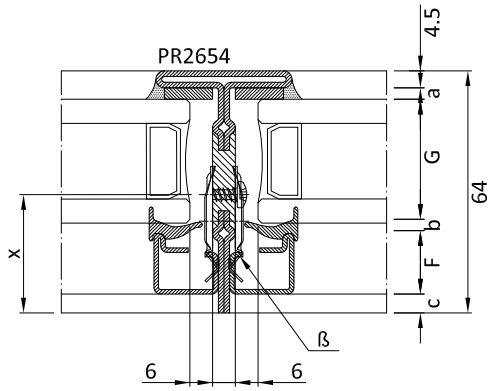


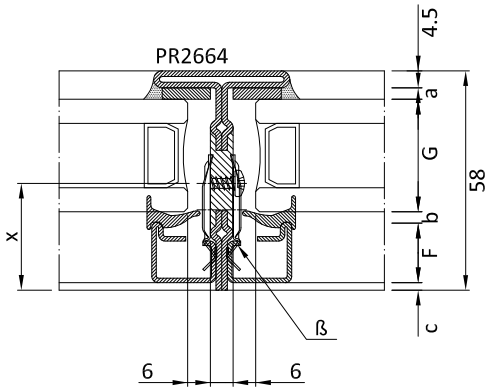


F	G	Guarnizioni - *gasket*						
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*		rientro fermavetro *glazing beads gap*		clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm	a	b	x	y	c	d	ß
 PR2606	24 - 32	3	3	27 * - 26	34 * - 33	15 - 7	8 - 0	AC2608
 PR2607	24 - 29			31 - 26	38 - 33	12 - 7	5 - 0	AC2608
 PR2627	24 - 29			31 - 26	38 - 33	12 - 7	5 - 0	AC2608
 PR2629	24 - 25			32 * - 30 *	39 * - 37 *	9 - 7	2 - 0	AC2608
 PR2638	27 - 28			35 * - 34 *	42 * - 41 *	8 - 7	1 - 0	AC2608

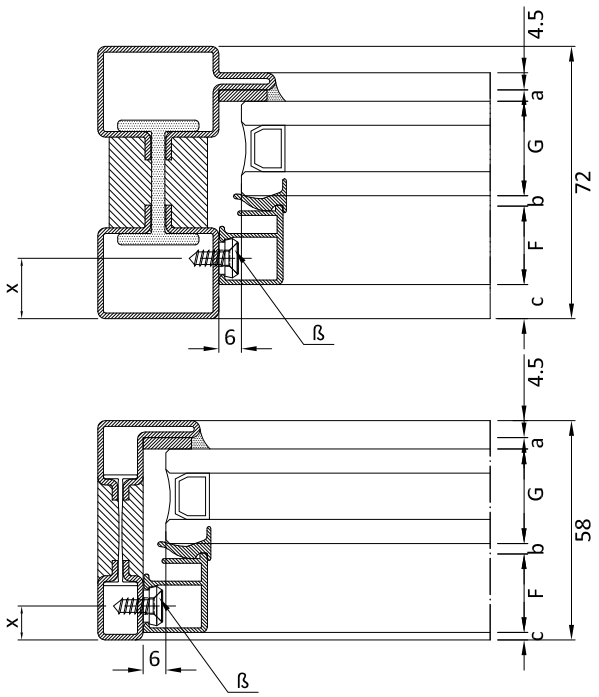
** 7 mm per PR2638
** *7 mm for PR2638*

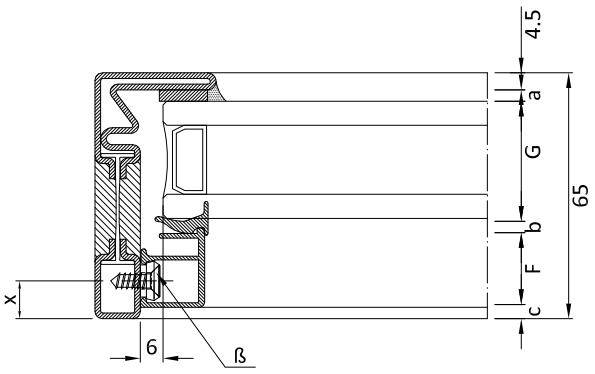
* fissare tramite il primo foro della clip
* *screw in the upper hole of the clip*



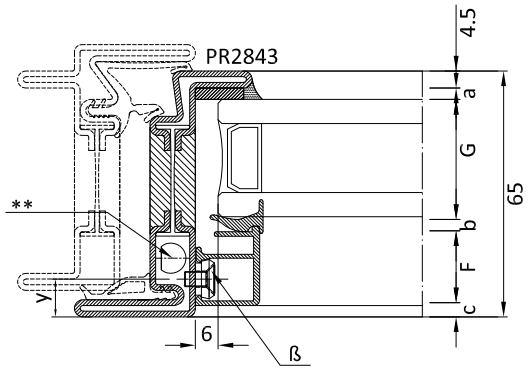


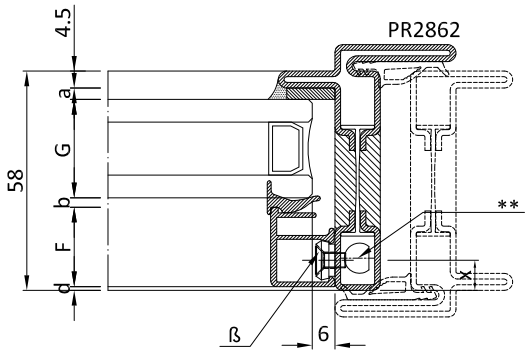
F	G		Guarnizioni - *gasket*						
fermavetro *glazing beads*	spessore vetro *glass thickness*		GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*		rientro fermavetro *glazing beads gap*		clips fissaggio fermavetro *glazing beads securing clips*
codice *code*	mm		a	b	x		c		ß
	P2654	P2664			P2654	P2664	P2654	P2664	
16 / 1.2 / 17 PR2606	30 - 35	35 - 32	3	3	34 - 29	28 - 26	8 - 3	2 - 0	AC2609
19 / 1.2 / 17 PR2607	27 - 32	27 - 29			34 - 29	28 - 26	8 - 3	2 - 0	AC2609
19 / 1.2 / 17 PR2627	27 - 32	27 - 29			34 - 29	28 - 26	8 - 3	2 - 0	AC2609
19 / 1.2 / 15 PR2638	27 - 34	28 - -			41 * - 41	35 *	7 0	0	AC2608





F	G			Guarnizioni - *gasket*									
fermavetro *glazing beads*	spessore vetro *glass thickness*			GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*			rientro fermavetro *glazing beads gap*			boccole e viti fissaggio fermavetro *Bushing and screws for fixing of glazing bead*
	mm					x			c			
codice *code*	Fisso 72 *Fix 72*	Fisso 65 *Fix 65*	Fisso 58 *Fix 58*	a	b	Fisso 72 *Fix 72*	Fisso 65 *Fix 65*	Fisso 58 *Fix 58*	Fisso 72 *Fix 72*	Fisso 65 *Fix 65*	Fisso 58 *Fix 58*	ß
PA2606 (15.5 × 17)	26 - 39	33 - 39	26 - 32	3	3	20 - 7	13 - 7	13 - 7	13 - 0	6 - 0	6 - 0	CV1023(i) CV5012(i)
PA2607 (21 × 1.2 × 17)	23 - 34	28 - 34	22 - 27			18 - 7	13 - 7	13 - 7	11 - 0	6 - 0	6 - 0	CV1023(i) CV5012(i)
PA2608 (27 × 1.2 × 17)	22 - 28	22 - 28	--			13 - 7	13 - 7	--	11 - 0	6 - 0	--	CV1023(i) CV5012(i)

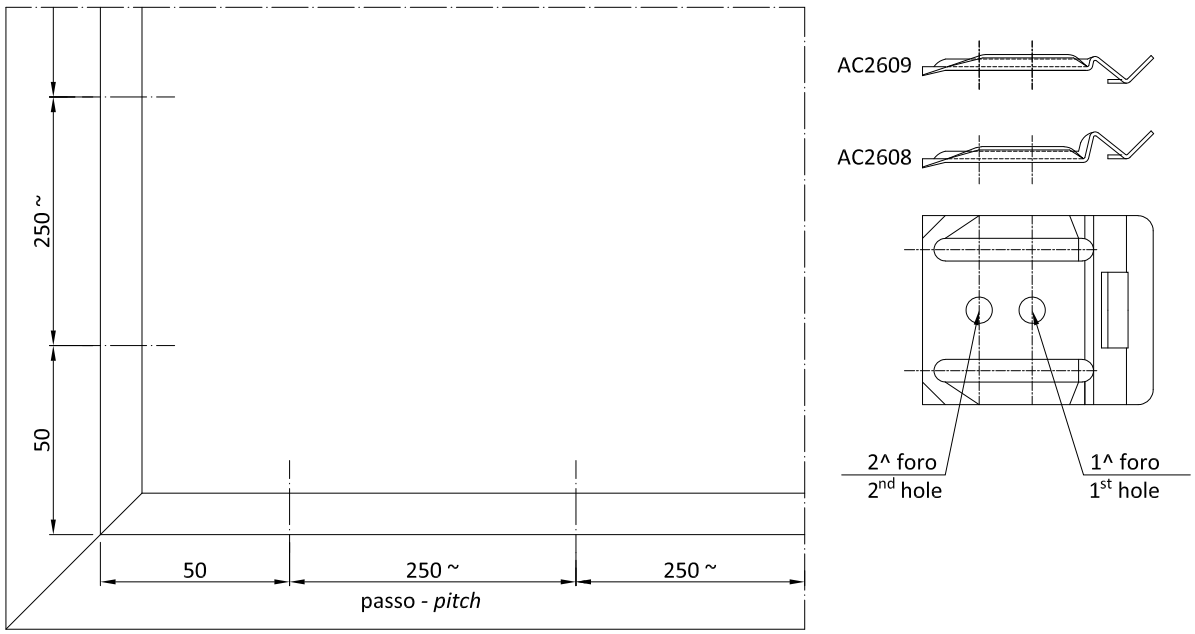




F	G	Guarnizioni - *gasket*						
fermavetro *glazing beads*	spessore vetro *glass thickness*	GU2036 3 mm + sigillatura *+ seal*	GP0095 2 / 3 mm	asse fissaggio viti fermavetro *glazing beads securing axis*		rientro fermavetro *glazing beads gap*		boccole e viti fissaggio fermavetro *Bushing and screws for fixing of glazing bead*
codice *code*	mm	a	b	x	y	c	d	ß
PA2606 (15.5 × 17)	28 - 32	3	3	18 - 14	11 - 7	11 - 7	4 - 0	CV1243(i) CV5012(i)
PA2607 (21 × 17, 1.2)	23 - 27			18 - 14	11 - 7	11 - 7	4 - 0	CV1243(i) CV5012(i)
PA2608 (27 × 17, 1.2)	21			14	7	7	0	CV1243(i) CV5012(i)

** Fare attenzione al fissaggio fermavetro in prossimità kit cremonese - vedi pg. 2.8.7
*** Pay attention fixing the screw near cremone set - see pg. 2.8.7*

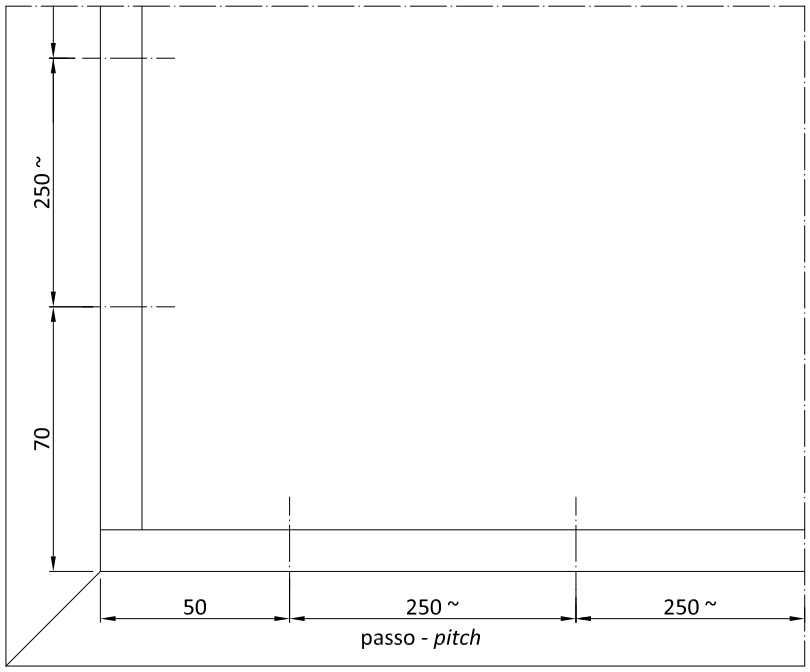
Fissaggio fermavetri PR2606 - PR2607 - PR2627 - PR2629: clip AC2608/AC2609 con vite TC 3.5 x 9.5 (non fornite)
Glazing beads fixing PR2606 - PR2607 - PR2627 - PR2629: clip AC2608 /AC2609 with screw TC 3.5 x 9.5 (not included)



Passo clips fissaggio fermavetri
Clip pitch for glazing beads securing

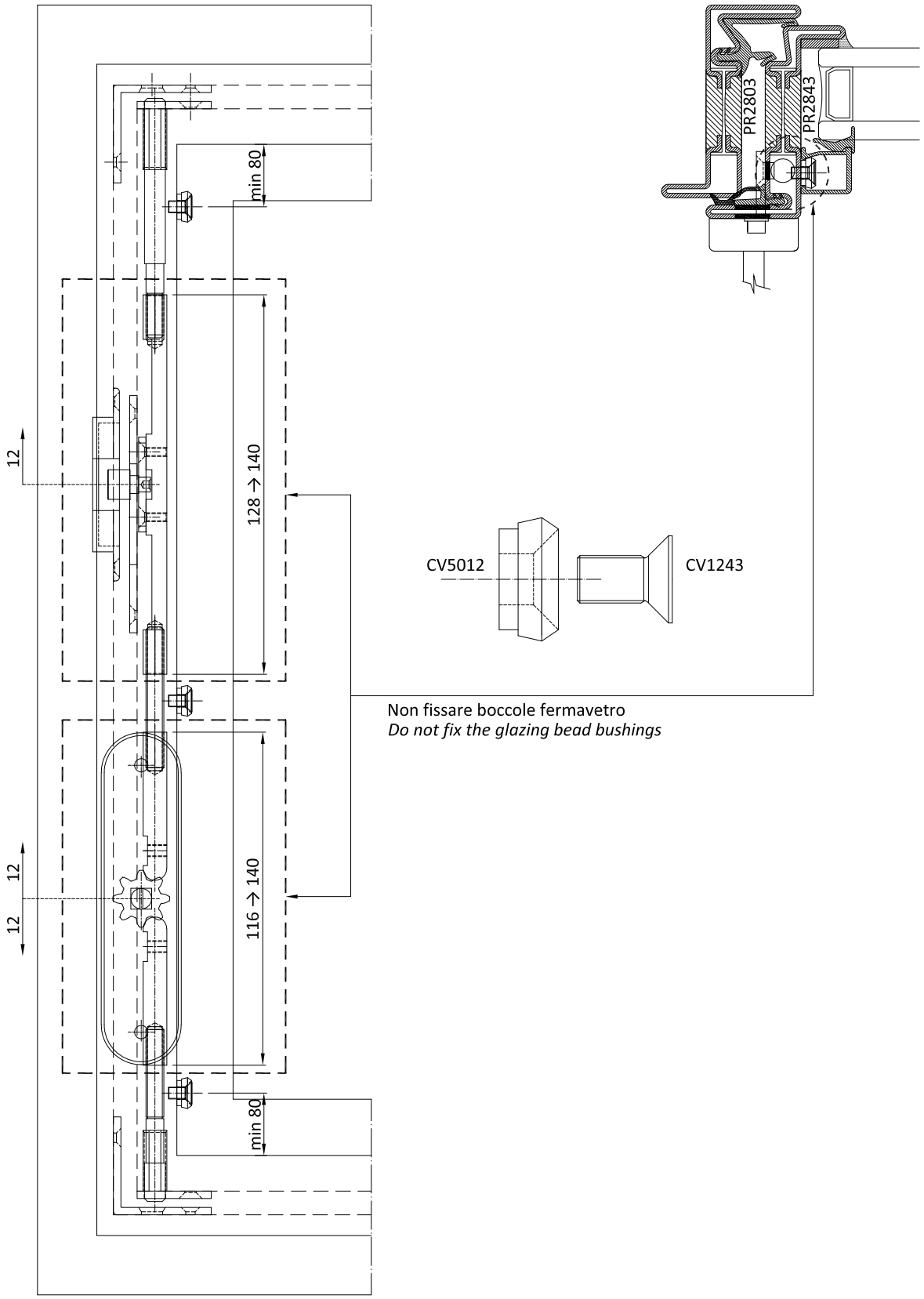
Fissaggio fermavetri PA2607 - PA2608: profili telaio vite CV1023(I) TPS 4,2 x 13 e boccola CV5012(I)
Profili anta vite CV1243(I) TPS M4 x 8 e boccola CV5012(I).

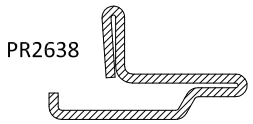
Glazing bead fixing PA2607 - PA2608: frame profile screw CV1023(I) TPS 4,2 x 13 and bushing CV5012(I)
Leaf profile screw CV1243(I) TPS M4 x 8 M4 x 8 and bushing CV5012(I).

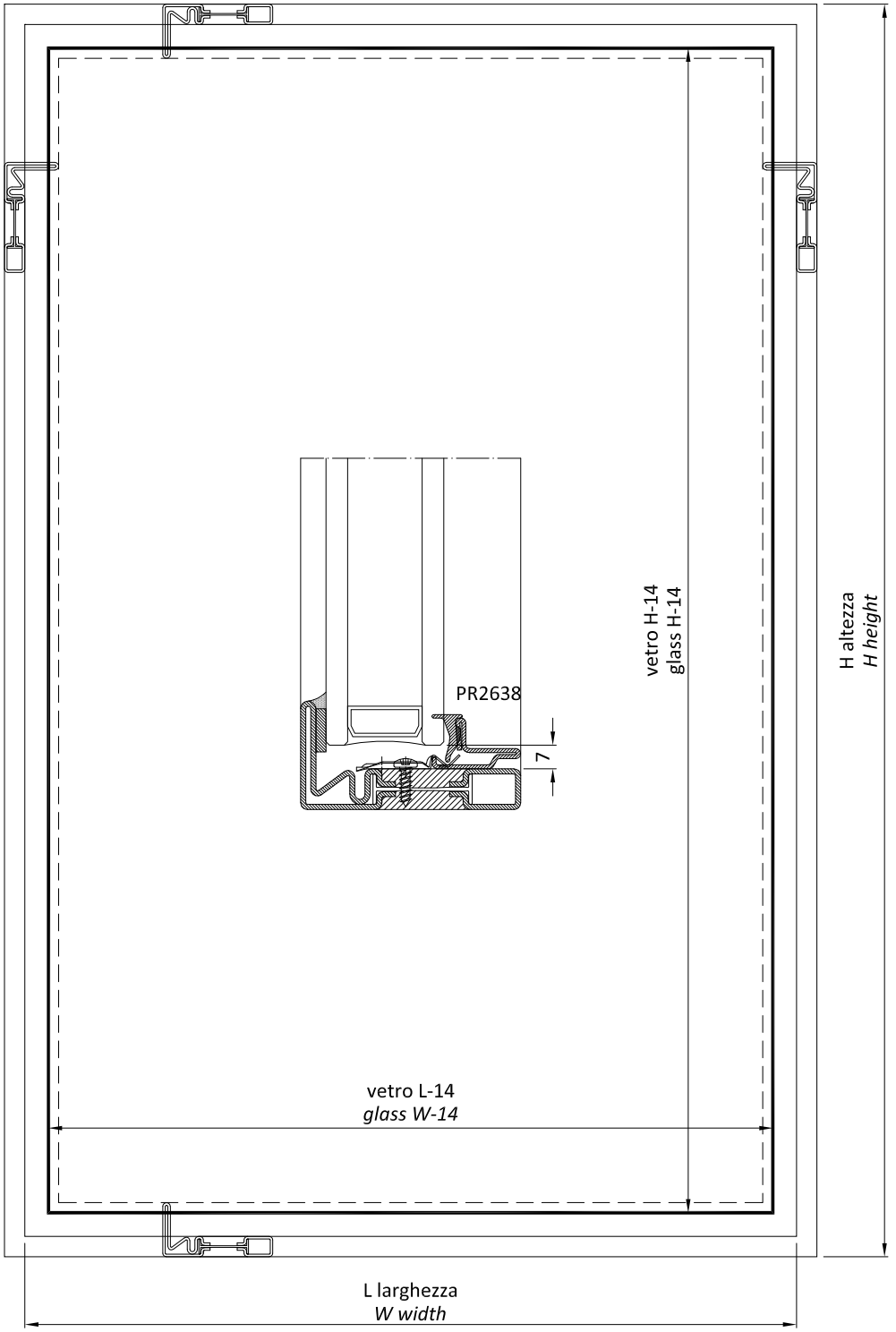


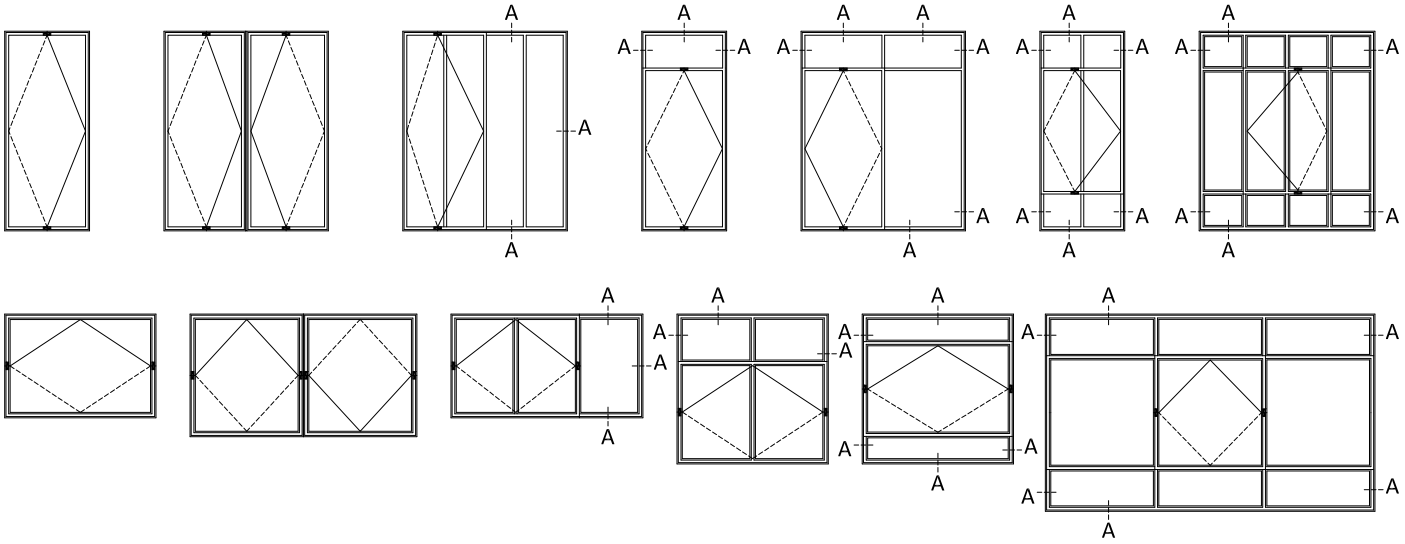
Passo vite e boccola fissaggio fermavetri
Screw and bushing pitch for glazing beads fixing

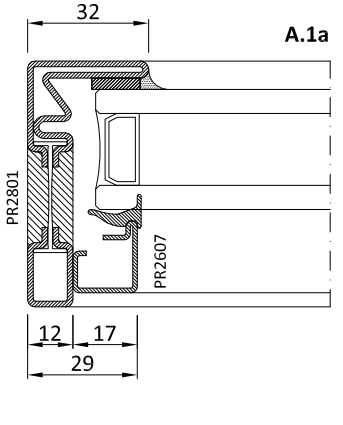
Boccole fissaggio fermavetri in alluminio
Bushing fixing for alluminium glazing beads

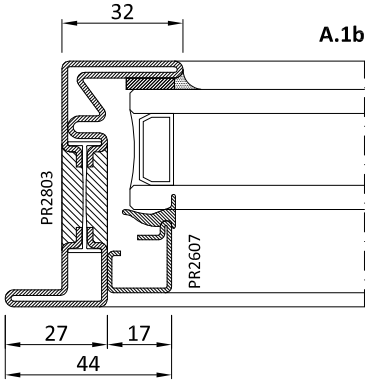



PR2638


PR2638
7
vetro H-14
glass H-14
H altezza
H height
vetro L-14
glass W-14
L larghezza
W width


A


A.1a
32
PR2801
PR2607
12
17
29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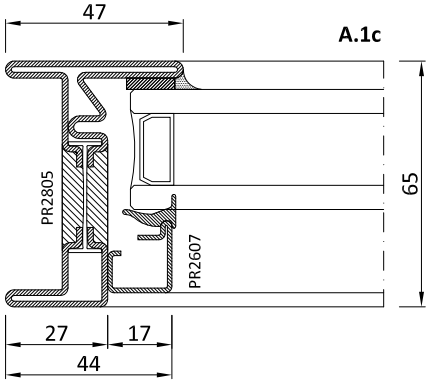
PR2803
PR2607
27
17
44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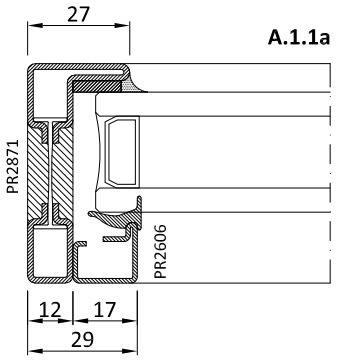
PR2805
PR2607
65
27
17
44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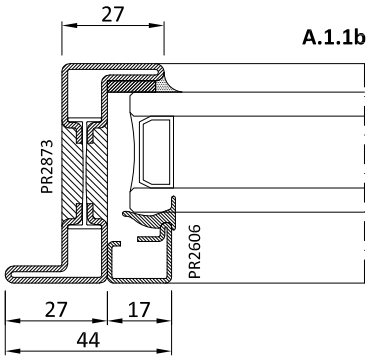
PR2871
PR2606
12
17
29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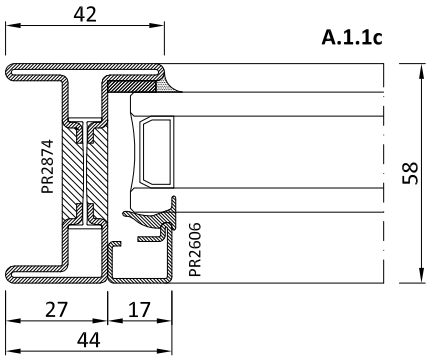
PR2873
PR2606
27
17
44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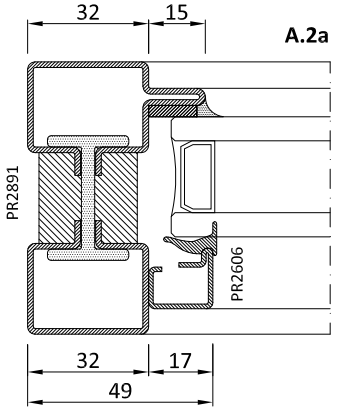
PR2874
PR2606
58
27
17
44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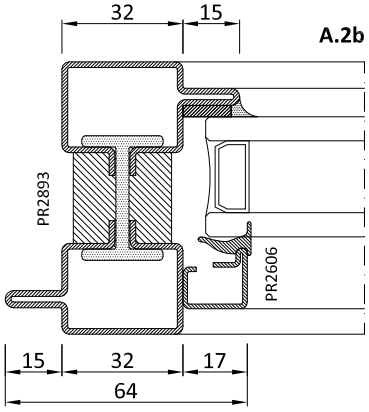
15
PR2891
PR2606
32
17
49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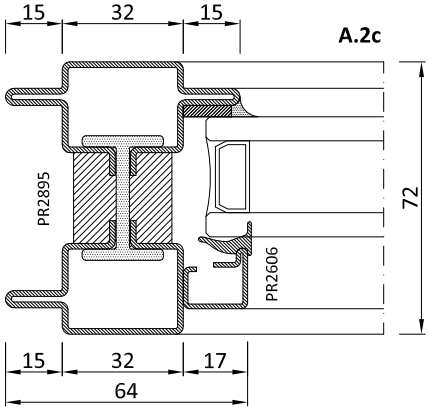
15
PR2893
PR2606
15
32
17
64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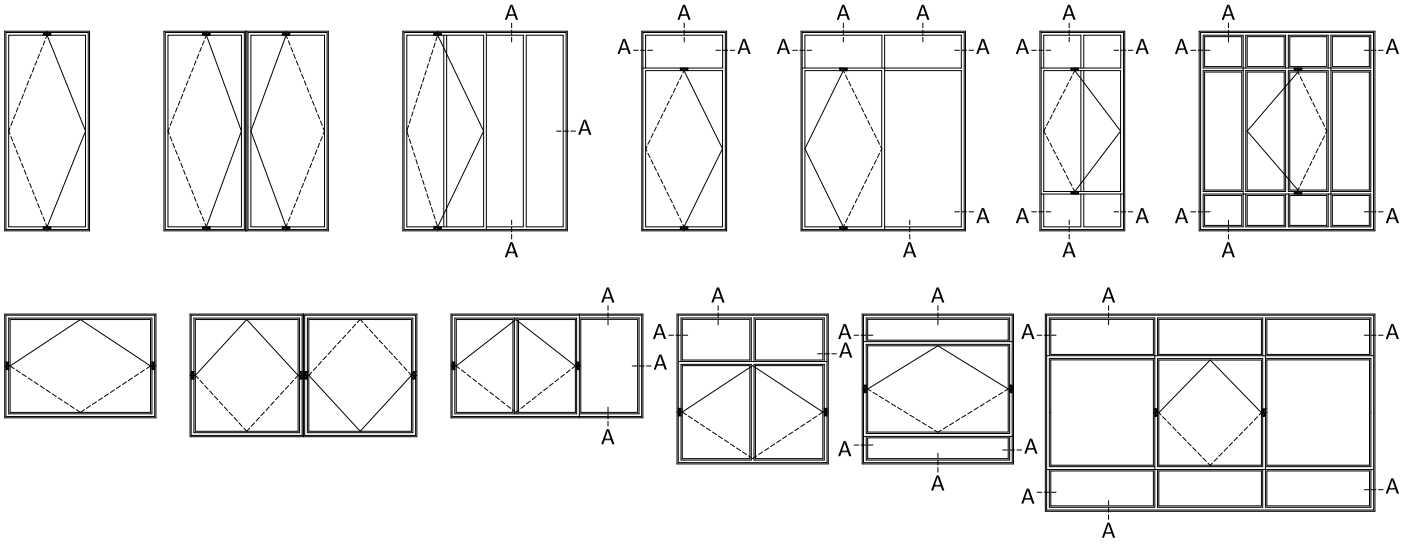
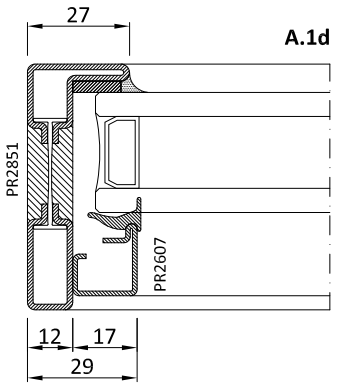
15
32
15
PR2895
PR2606
72
15
32
17
64


A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PR2851
PR2607
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17
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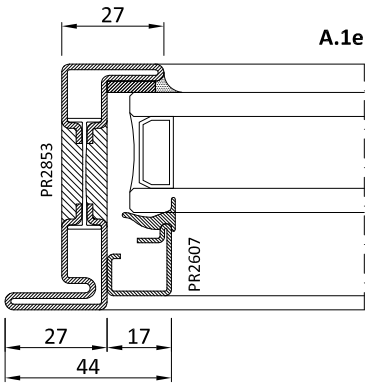
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PR2607
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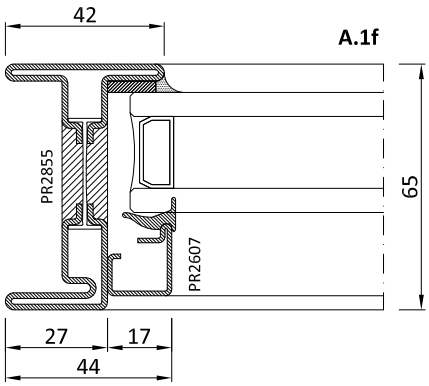
17
44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PR2855
PR2607
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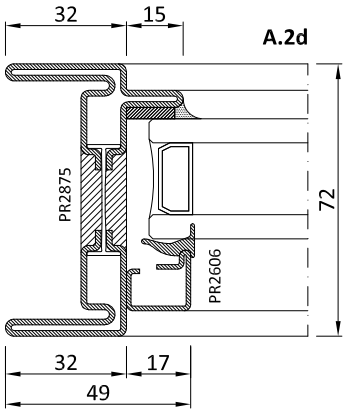
27
17
44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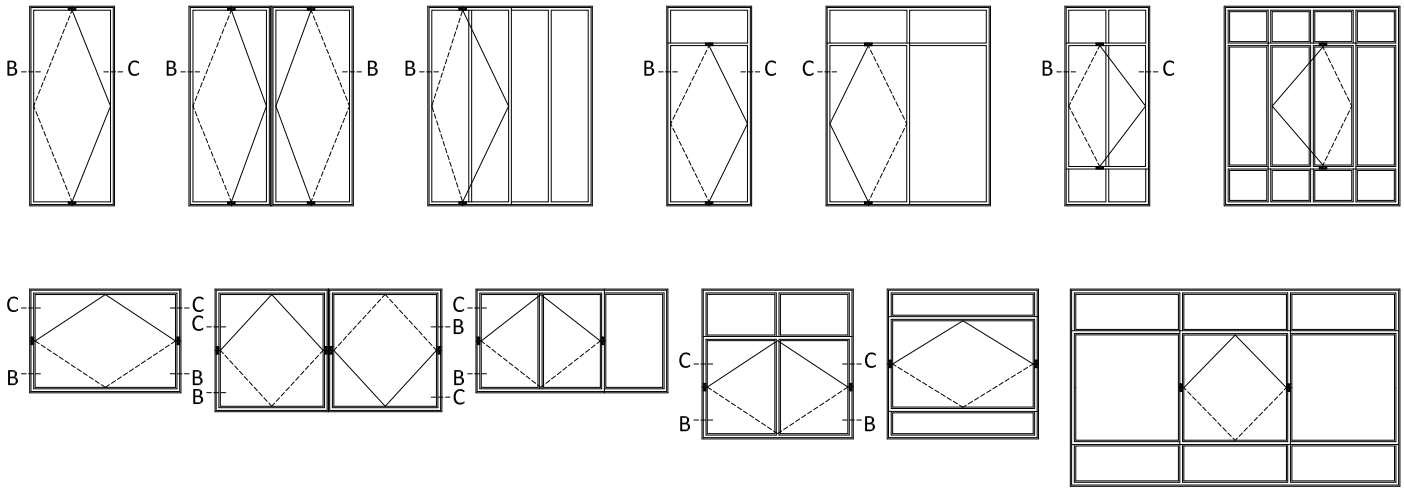
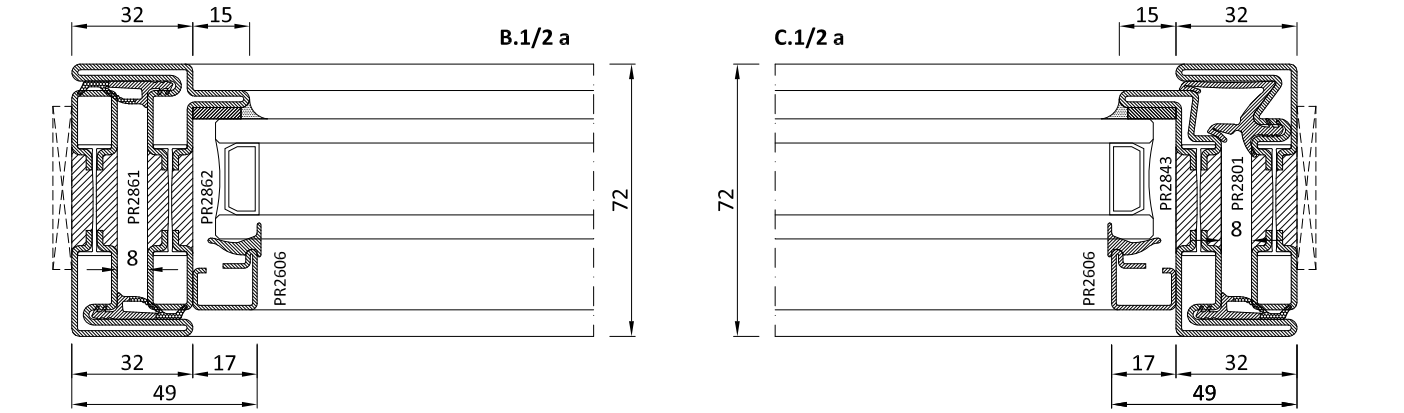
PR2875
PR2606
72
32
17
49


B
C


B.1/2 a
32
15
PR2861
PR2862
PR2606
8
72
32
17
49

C.1/2 a
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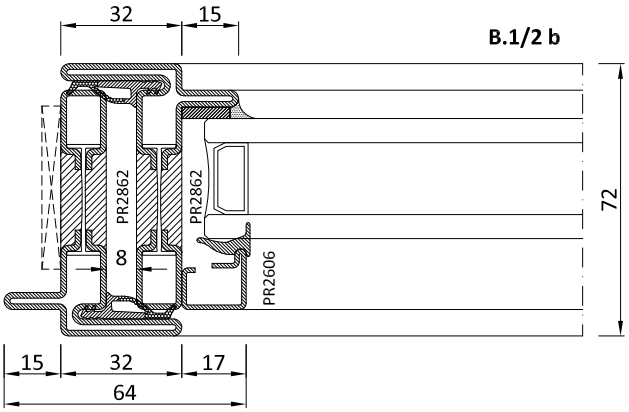
32
PR2843
PR2801
PR2606
8
72
17
32
49


B.1/2 b
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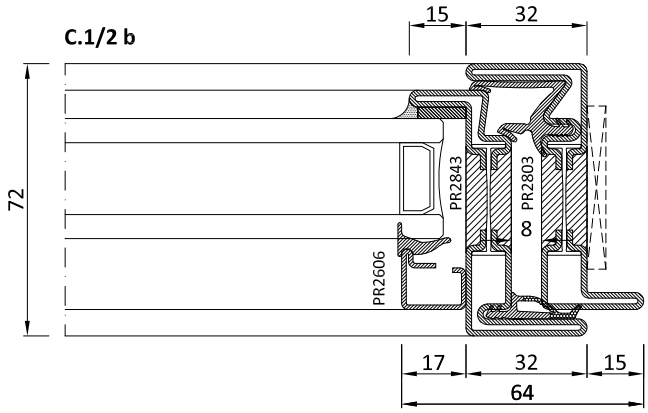
15
PR2862
PR2862
PR2606
8
72
15
32
17
64


C.1/2 b
15
32
PR2843
PR2803
PR2606
8
72
17
32
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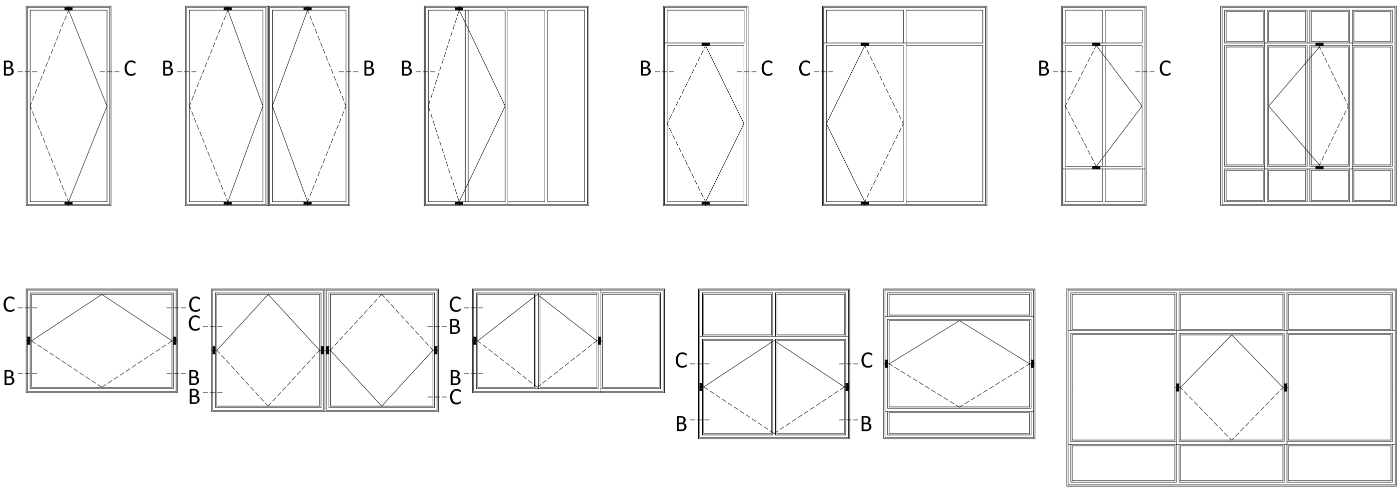
64



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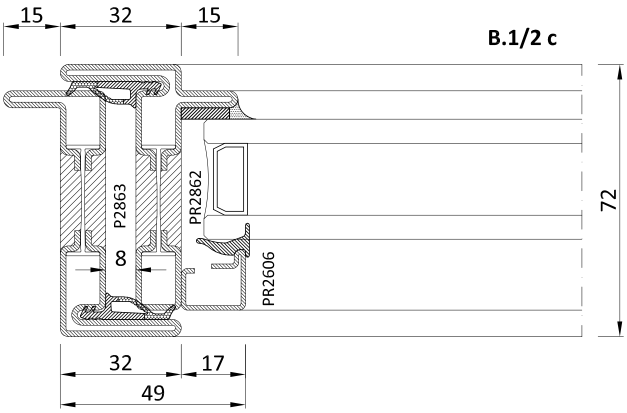
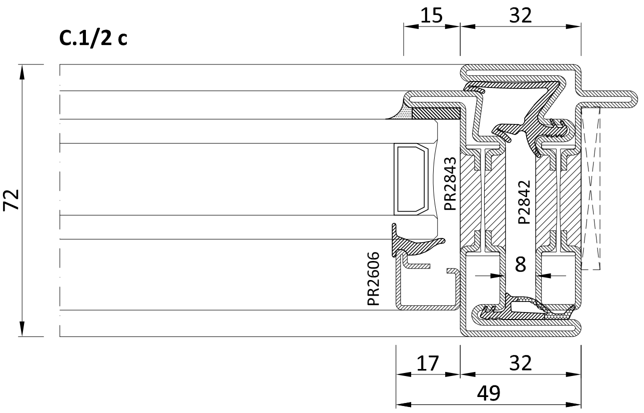


C.1/2 c



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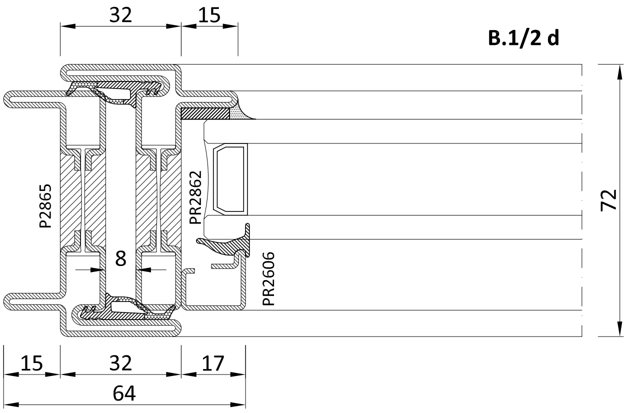

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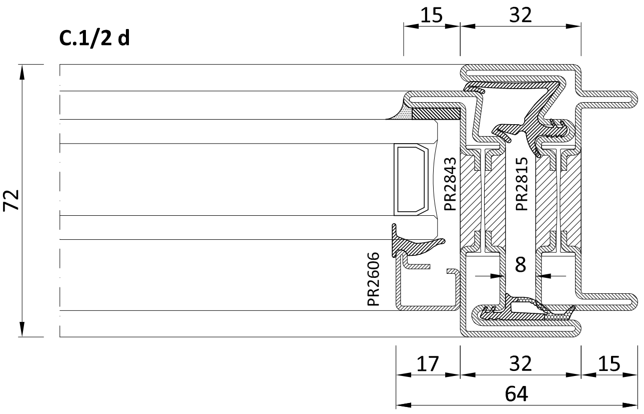

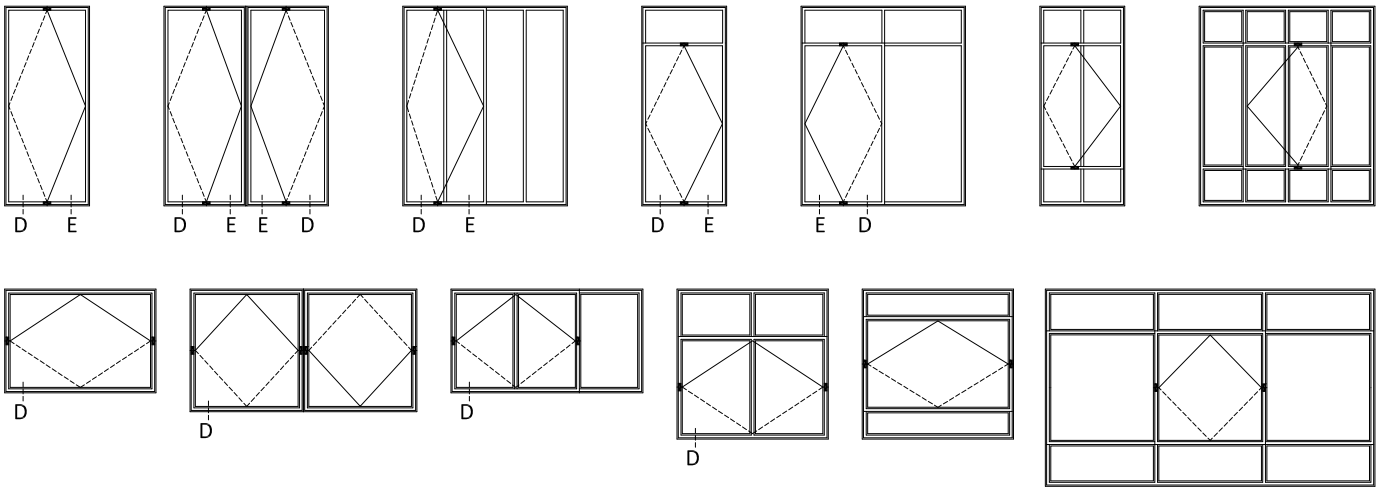

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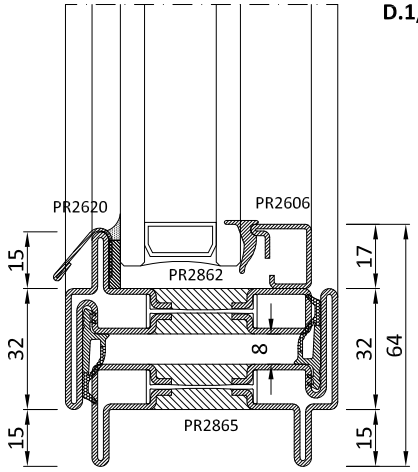

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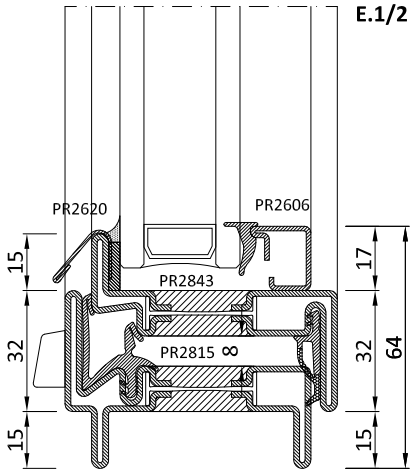

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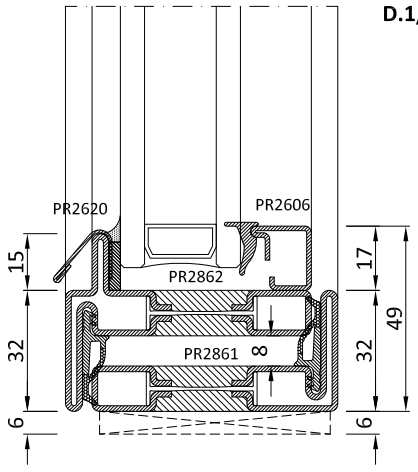

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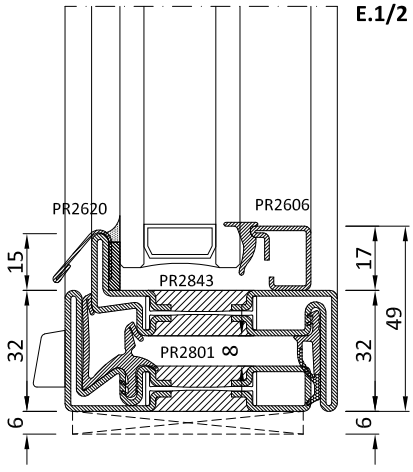

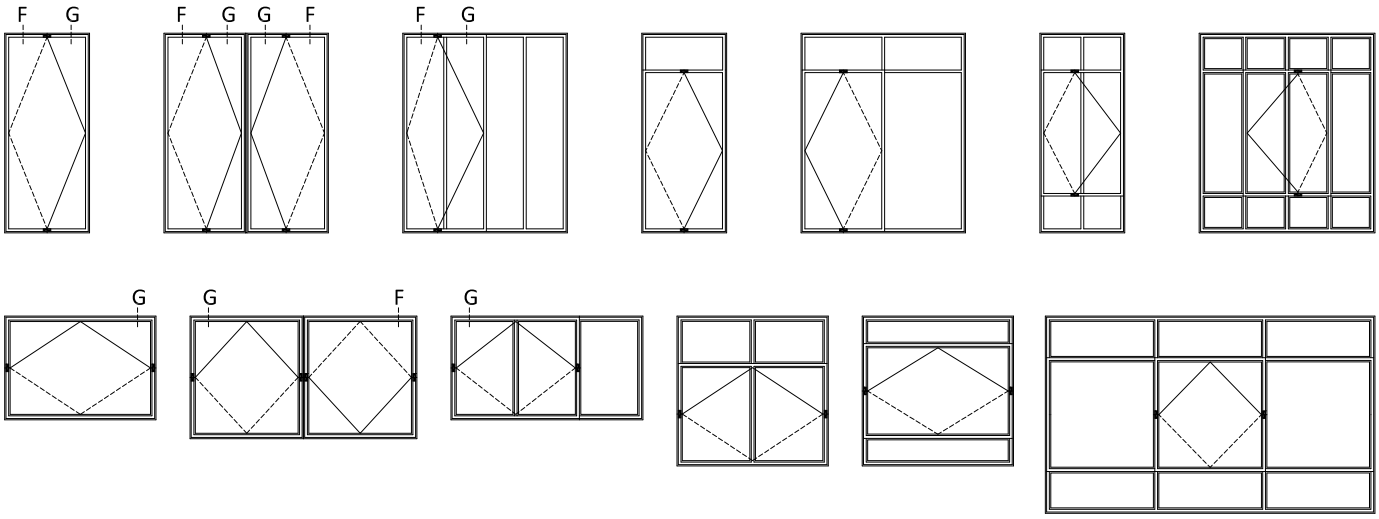

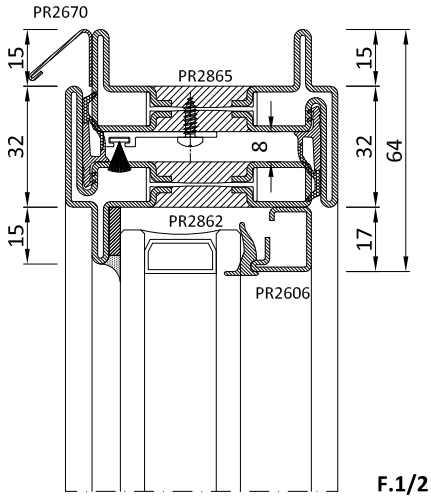

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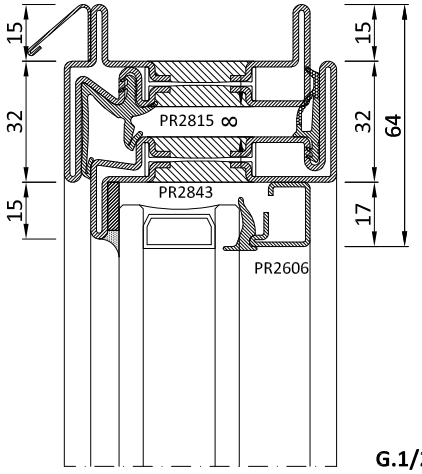

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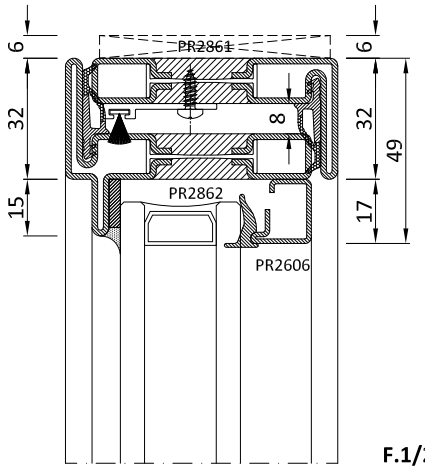

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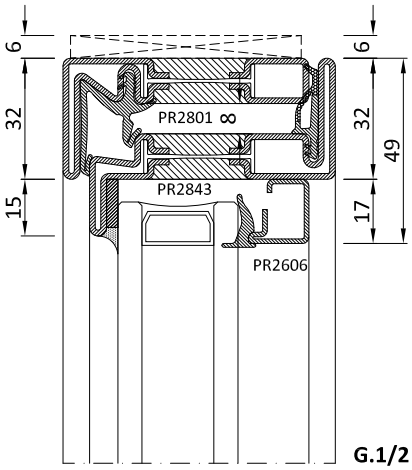

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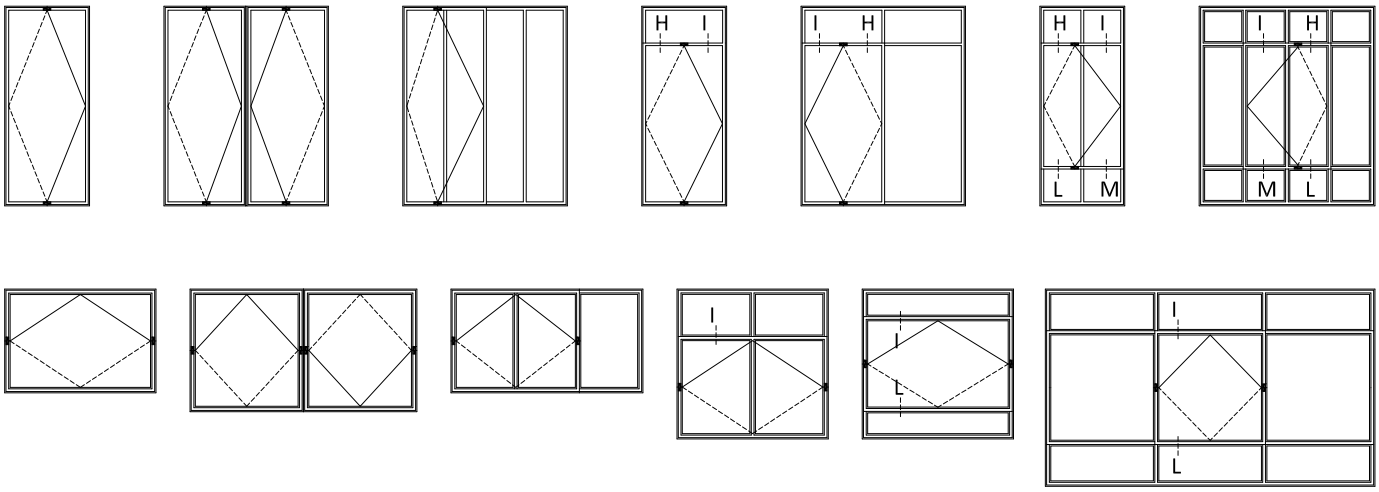
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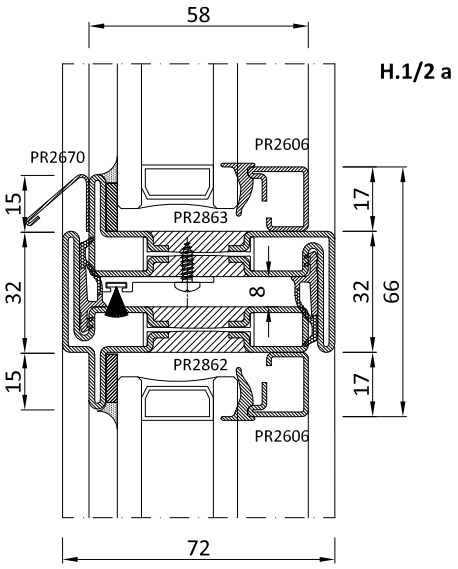
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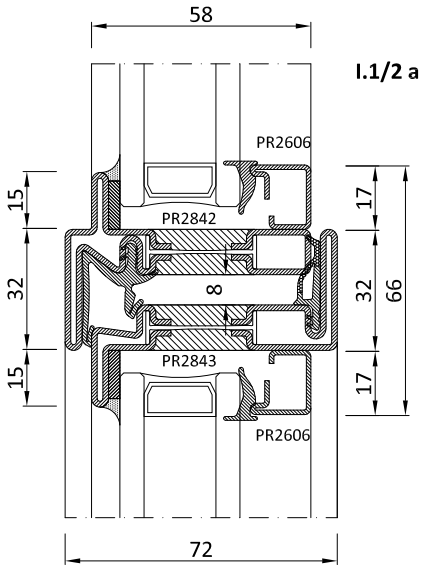
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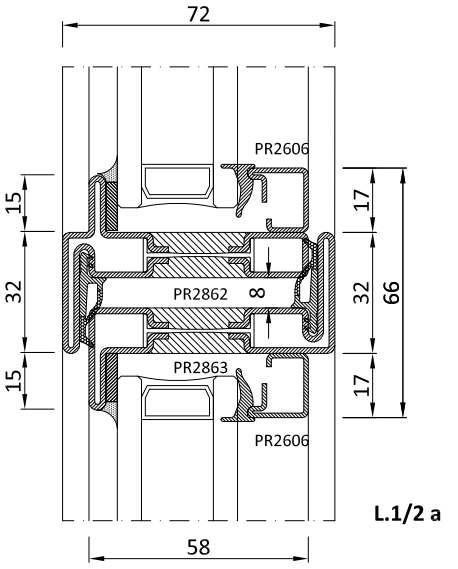
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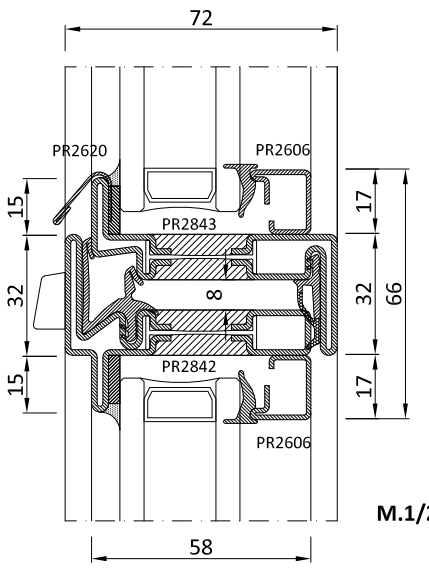
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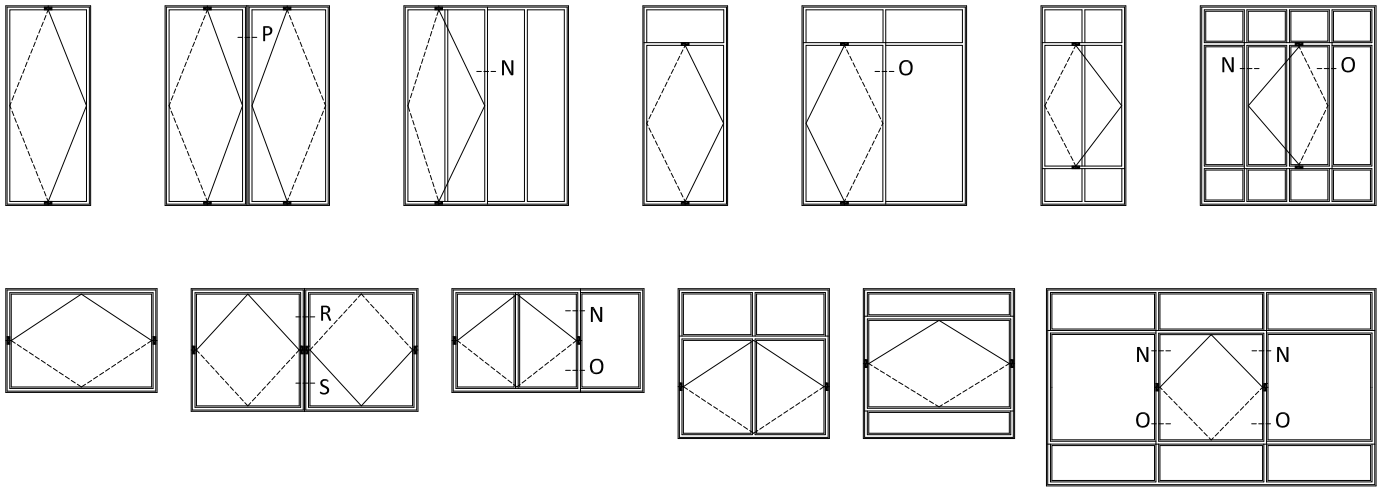
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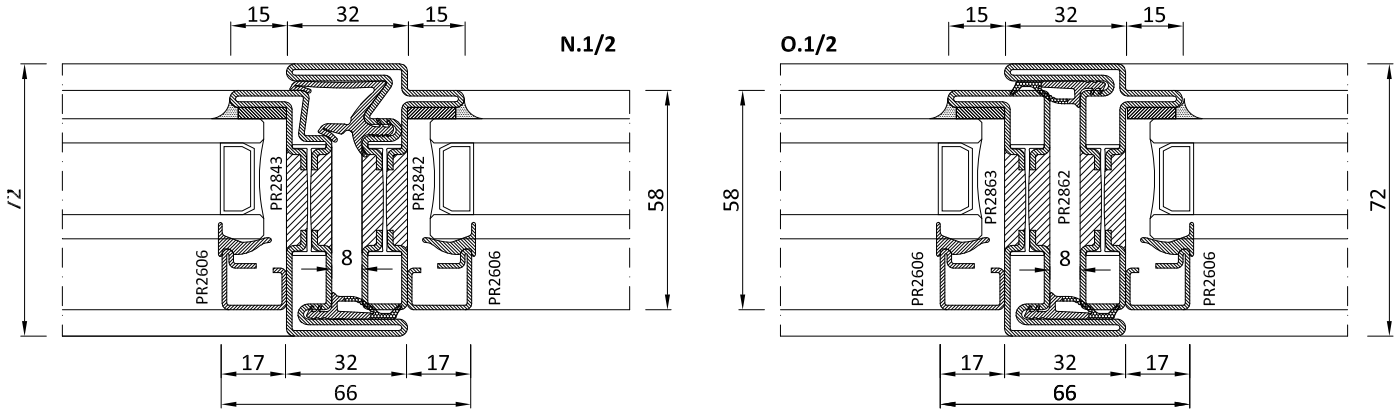
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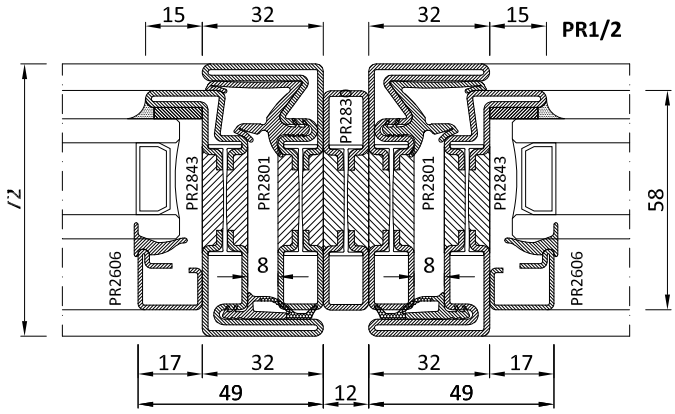
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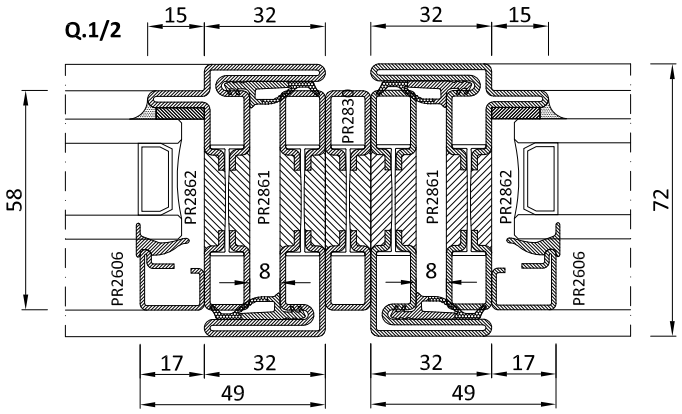
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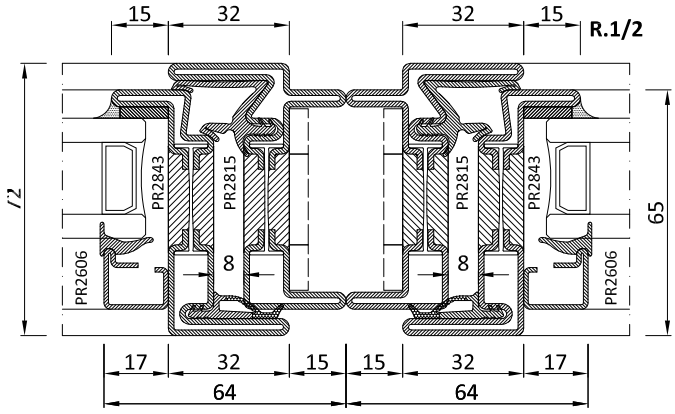
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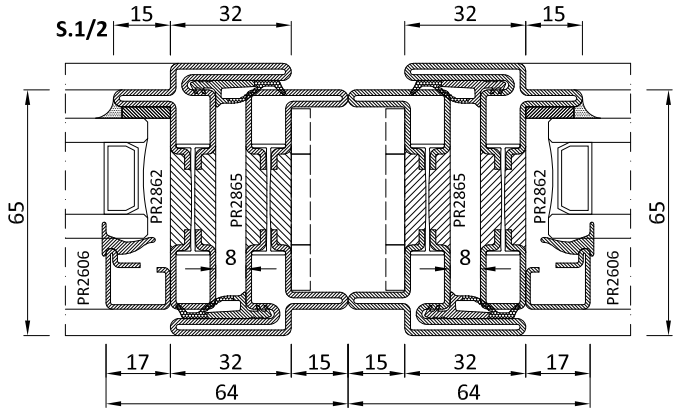
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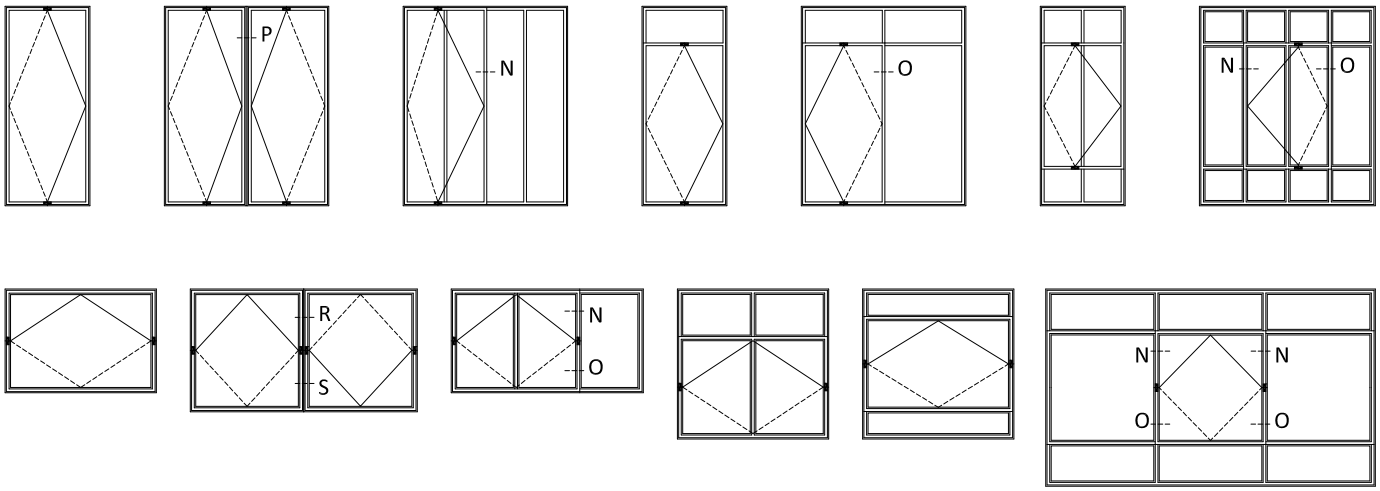
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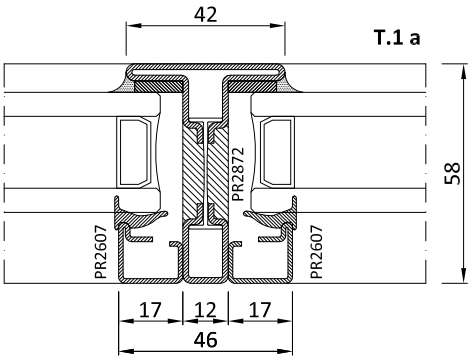
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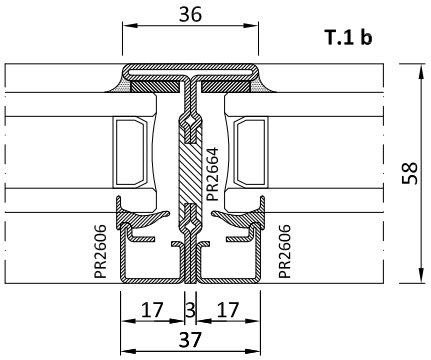
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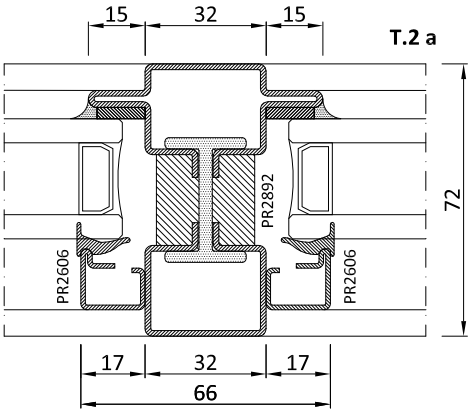
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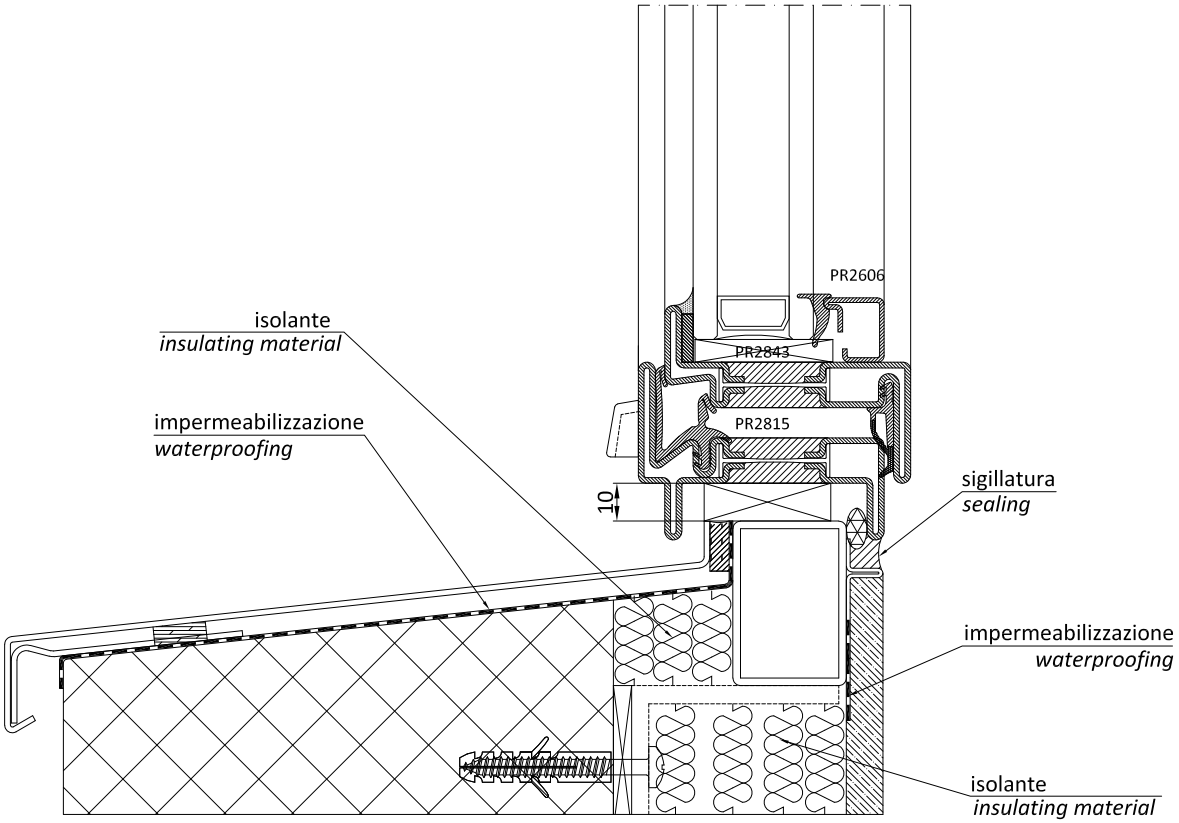
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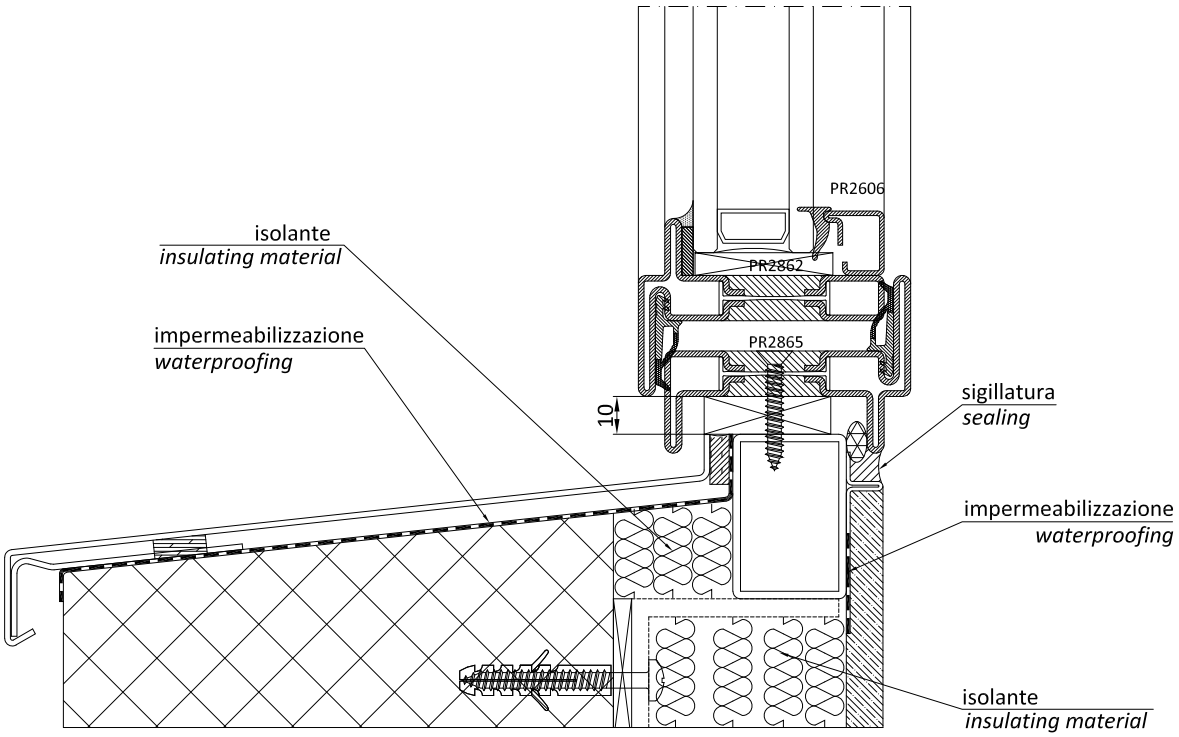
impermeabilizzazione
waterproofing
sigillatura
sealing
impermeabilizzazione
waterproofing
isolante
insulating material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sealing
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waterproofing
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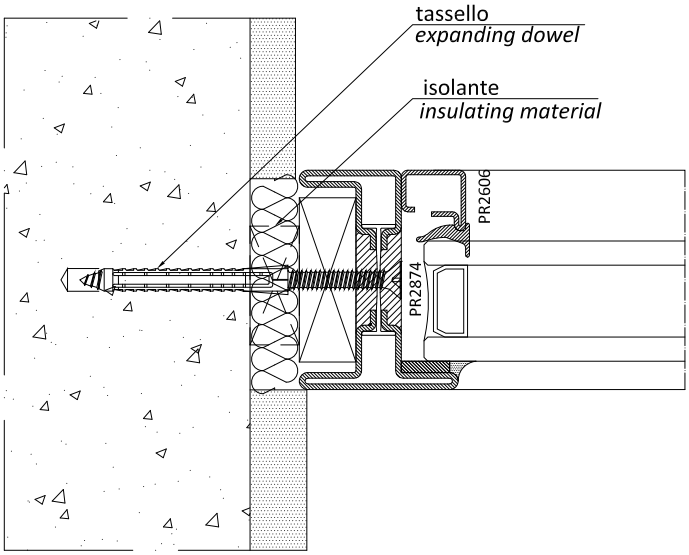
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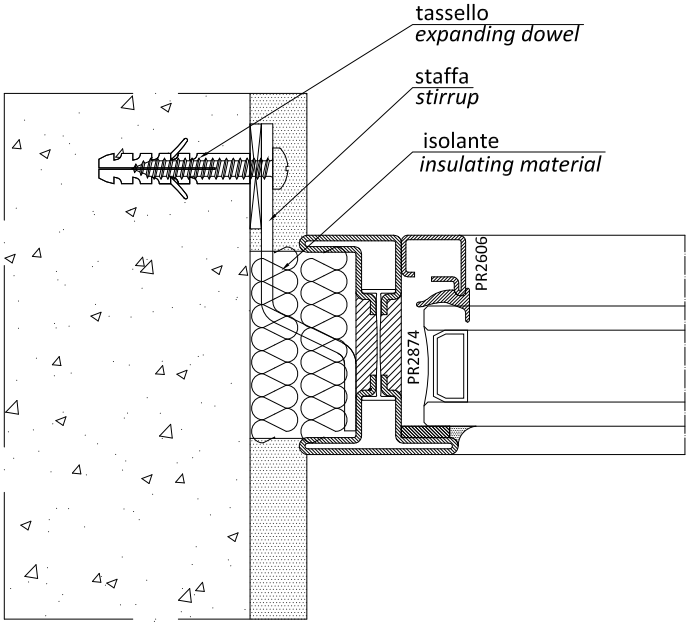
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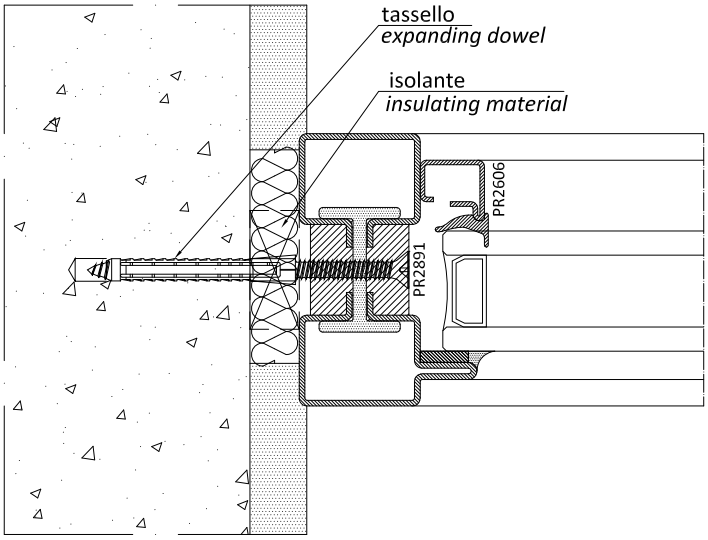
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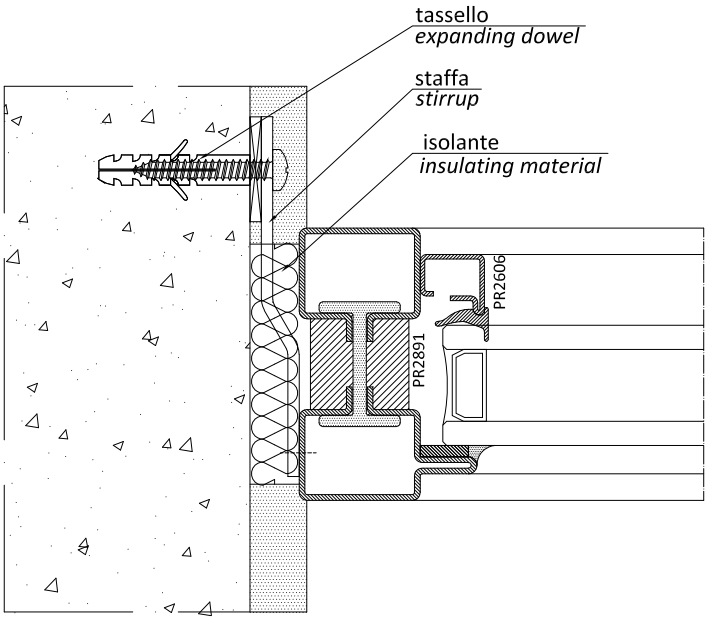
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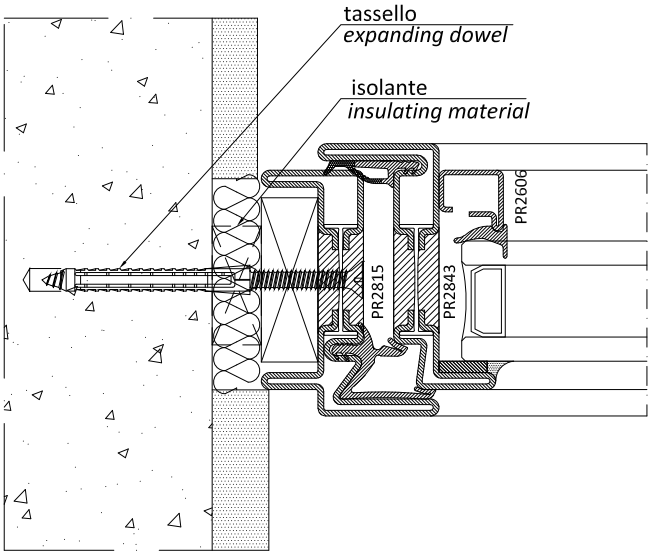
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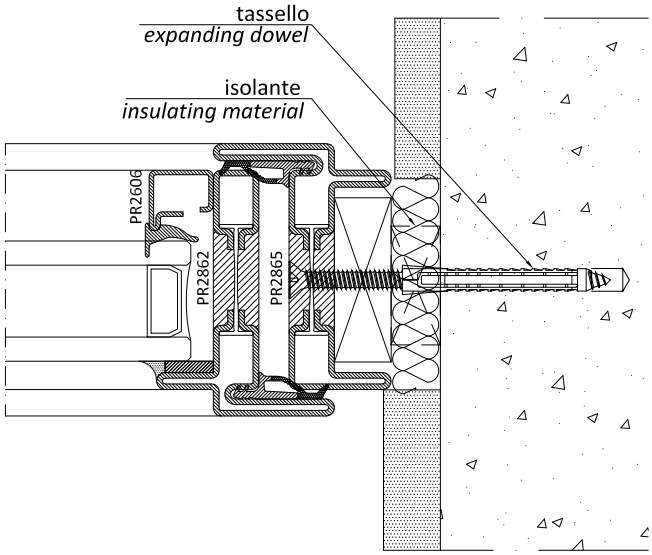
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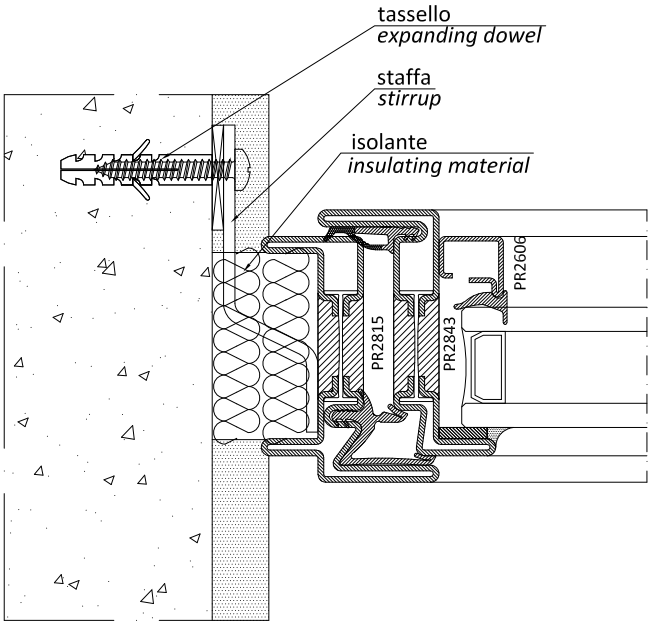
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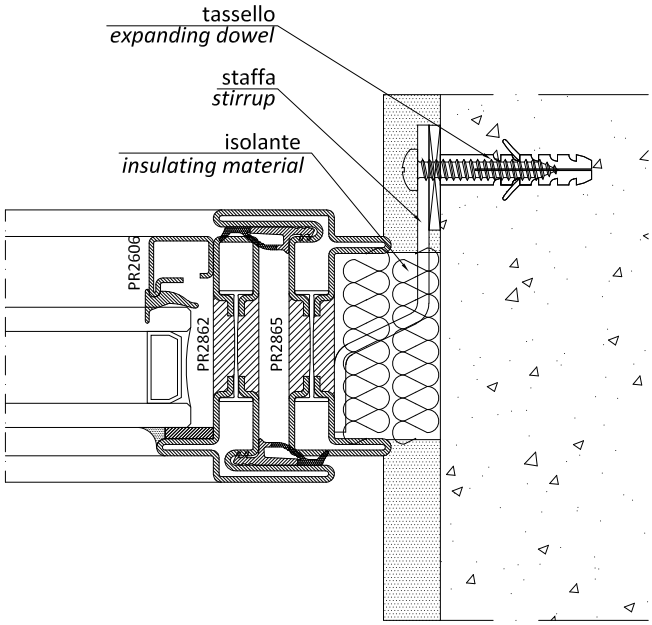
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expanding dowel
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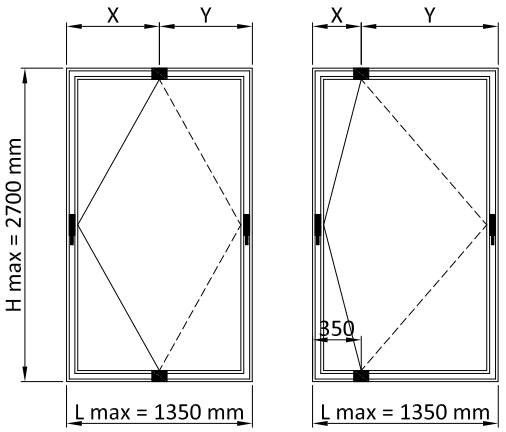
isolante
insulating material
PR2606
PR2862
PR2865

Lavorazioni su barra / *Section working*	
Taglio / *Cut*	5.1.1-2 | 5.2.1-2
Fori e asole per cremonese / *Cremone bolt holes and slots*	4.3.7-9
Fori e asole per chiusura supplementare / *Additional locking points slots and holes*	4.3.10-11
Fori per scarico acqua / *Water drip holes*	4.3.4
Lavorazione inserimento snodo bilico / *Working for pivot bearing*	4.3.12-15
Lavorazione gocciolatoio / *Water drip section workink*	4.3.5
Fori fissaggio a muro / *Wall mounting holes*	3.2.1-4
Assiemaggio / *Assembly*	
Costruzione telai / *Frame assembly*	
Saldatura / *Welding*	4.4.2-5
Inserimento squadrette (profili ottone) / *Brackets insertion (brass section)*	4.4.1-2
Applicazione accessori / *Accessories installation*	
Assiemaggio snood bilico / *Pivot bearing assembling*	4.4.6-18
Sequenza di assiemaggio / *Assembling sequence*	4.4.19
Preparazione per verniciatura e ossidazione / *Preparation for the powder coating - burnishing*	
Fori su telaio per scarichi liquidi pretrattamento / *Holes on frame for the drainage of pretreatment liquid*	5.1.4
Pulitura della superficie (ottone) / *Cleaning of the surface*	5.1.4-5
Montaggio accessori / *Accessories installation*	
Applicazione e sigillatura guarnizioni giunto aperto / *Sealing of central gasket*	4.5.1
Applicazione scarichi acqua / *Water drip installation*	4.5.1
Montaggio cremonese e incontri / *Cremone bolt installion*	4.5.2-6
Sigillatura angolo nel TT / *Corner joint sealing*	4.5.1
Vetrazione / *Glazing*	
Applicazione clips fermavetro / G*lazing bead clips installation*	2.8.1-8
Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)*	4.6.1



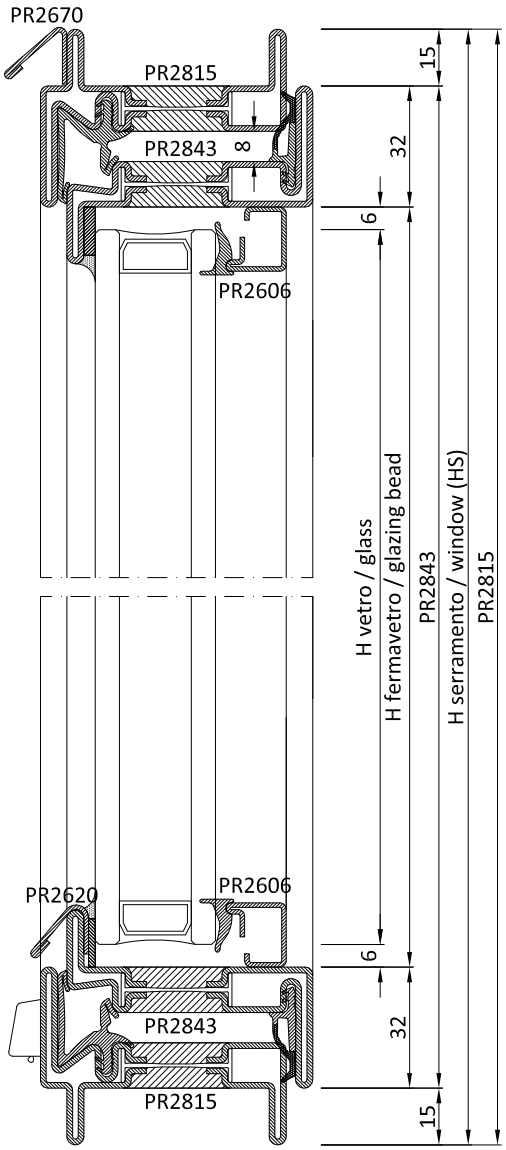
PROFILI *PROFILES*						
Codice *Code*	Descrizione *Descriprion*			Dim.	Taglio	*Cutting*
Telaio ***Frame***						
PR2815	Profilo telaio	*Profile frame*	1	(LS-80)/2	45°	90°
PR2815	Profilo telaio	*Profile frame*	1	(LS-80)/2	90°	45°
PR2815	Profilo telaio	*Profile frame*	1	HS	45°	45°
PR2865	Profilo telaio	*Profile frame*	1	(LS-80)/2	90°	45°
PR2865	Profilo telaio	*Profile frame*	1	(LS-80)/2	45°	90°
PR2865	Profilo telaio	*Profile frame*	1	HS	45°	45°
Anta ***Leaf***						
PR2843	Profilo anta	*Profile leaf*	1	(LS-110)/2	45°	90°
PR2843	Profilo anta	*Profile leaf*	1	(LS-110)/2	90°	45°
PR2843	Profilo anta	*Profile leaf*	1	HS-30	45°	45°
PR2862	Profilo anta	*Profile leaf*	1	(LS-110)/2	90°	45°
PR2862	Profilo anta	*Profile leaf*	1	(LS-110)/2	45°	90°
PR2862	Profilo anta	*Profile leaf*	1	HS-30	45°	45°
PR2620	Profilo battiacqua	*Water drip profile*	1	LS-99	90°	90°
PR2670	Profilo battiacqua	*Water drip profile*	1	LS-5	90°	90°
Fermavetri ***Glazing beads***						
PR2606	Profilo fermavetro	*Glazing beads profile*	2	LS-94	45°	45°
PR2606	Profilo fermavetro	*Glazing beads profile*	2	HS-94	45°	45°
Vetri ***Glass***						
	Vetro camera	*Double Glazing*	1	LS-106 x HS-106		

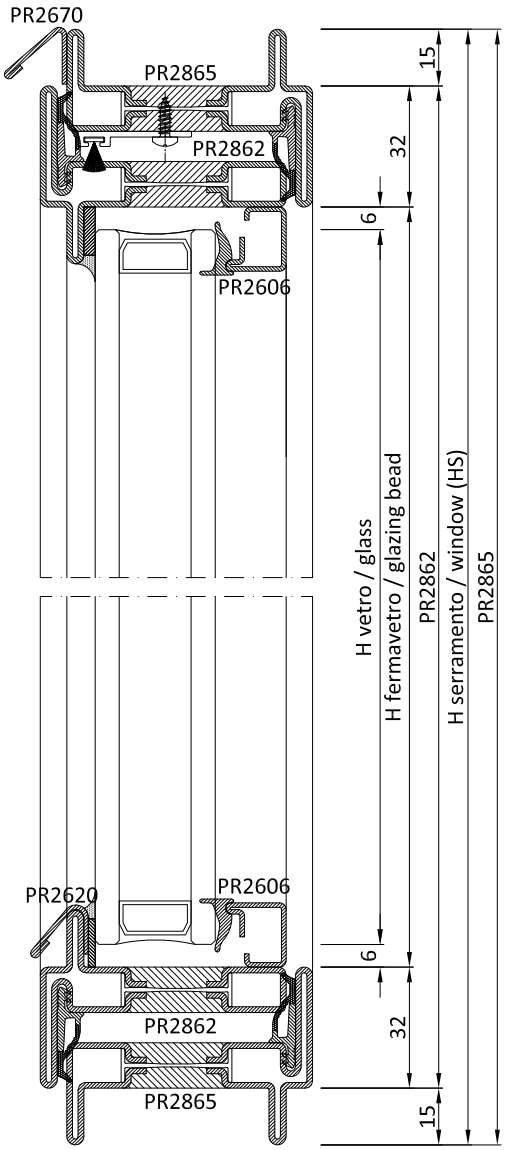
ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione *Descriprion*			Dim.
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2617N	Guarnizione d'angolo	*Vulcanised corner gasket*	2	
AC2618	Scarico acqua	*Water drip*	var.	
AC2633V	Coppia snodi bilico	*Pivot bearing*	1	
AC2625 D/S	Kit cremonese apertura interna	*Inwards opening cremone bolt set*	1	
AC2683 D/S	Kit cremonese apertura esterna	*Outwards opening cremone bolt set*	1	
AC2626R	Kit per terza chiusura	*Three-point lock system kit*	var.	
AC2686	Braccetto limitatore apertura	*Casement opening stays*	1	
ACV 77..	Maniglie "Vitruvio"	*Handle " Vitruvio"*	2	
AC2803I*	Kit squadrette per PR2815	*Corner brackets kit for PR2815*	2	
AC2843I*	Kit squadrette per PR2843	*Corner brackets kit for PR2843*	2	
AC2862I*	Kit squadrette per PR2862	*Corner brackets kit for PR2862*	2	
AC2865I*	Kit squadrette per PR2865	*Corner brackets kit for PR2865*	2	
GUARNIZIONI ***WEATHER STRIP***				
GE2645TT	Guarnizione di battuta	*Internal weather strip*	1	3xLS+3xHS
GE2603	Guarnizione giunto aperto	*Weather strip for open joint*	1	LS-110+HS
GU2036	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+2xHS
GU2865	Spazzolino superiore apertura esterna	*Upper brush seal outwards opening*	1	(LS-X)-67
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+2xHS

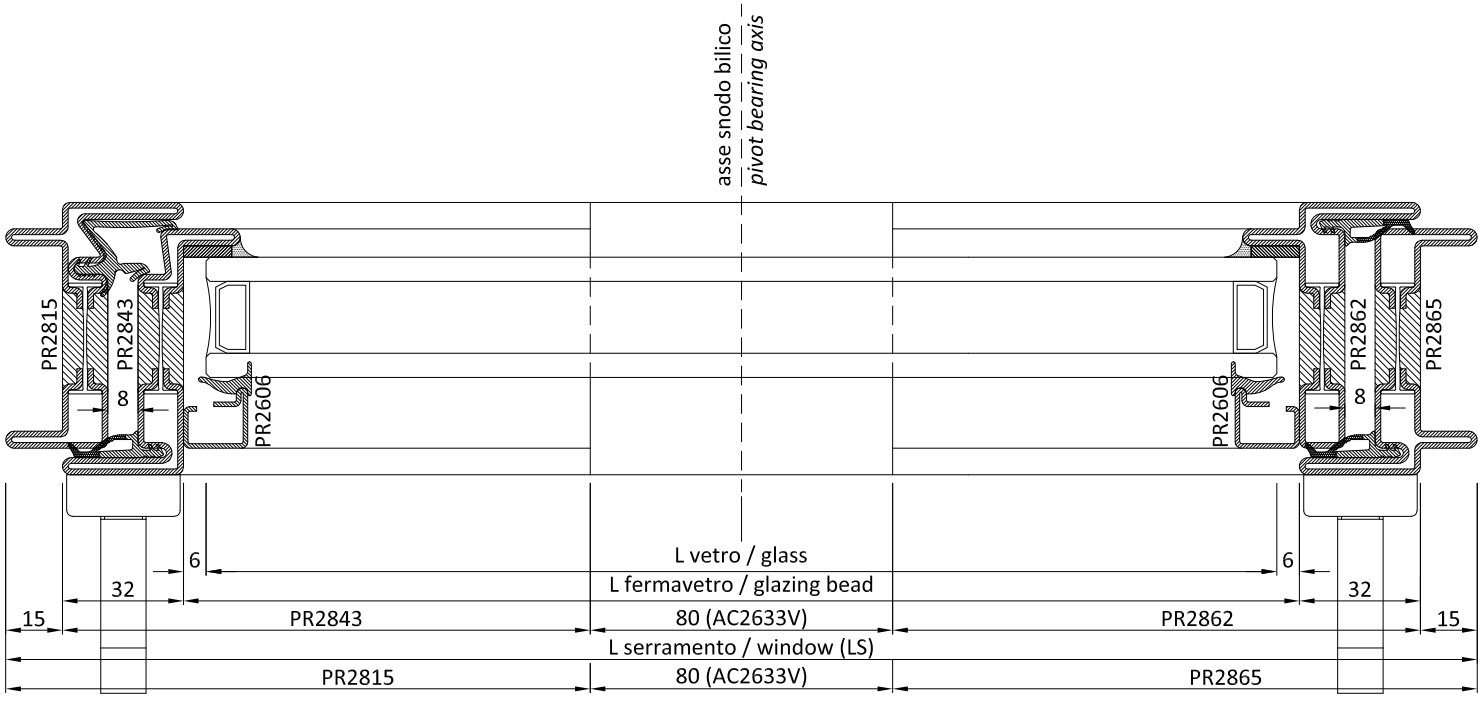
* solo con profili ottone | *only with brass profiles*

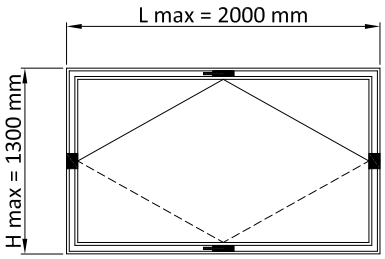
N.B.: le dimensioni delle guarnizioni sono indicative e devono essere aumentate del 10% per adattamenti e ritiri del materiale nel tempo

Attention: the gasket dimensions are indicative and have to be increased by 10% owing to adaptation and contractions of the material over time


PR2670
PR2815
PR2843
8
PR2606
15
32
6
H vetro / glass
H fermavetro / glazing bead
H serramento / window (HS)
PR2843
PR2815
PR2620
PR2606
6
32
15


PR2670
PR2865
PR2862
PR2606
15
32
6
H vetro / glass
H fermavetro / glazing bead
H serramento / window (HS)
PR2862
PR2865
PR2620
PR2606
6
32
15


asse snodo bilico
pivot bearing axis
PR2815
PR2843
8
PR2606
PR2606
PR2862
8
PR2865
6
32
15
PR2843
L vetro / glass
L fermavetro / glazing bead
80 (AC2633V)
L serramento / window (LS)
PR2815
80 (AC2633V)
6
32
15
PR2862
PR2865

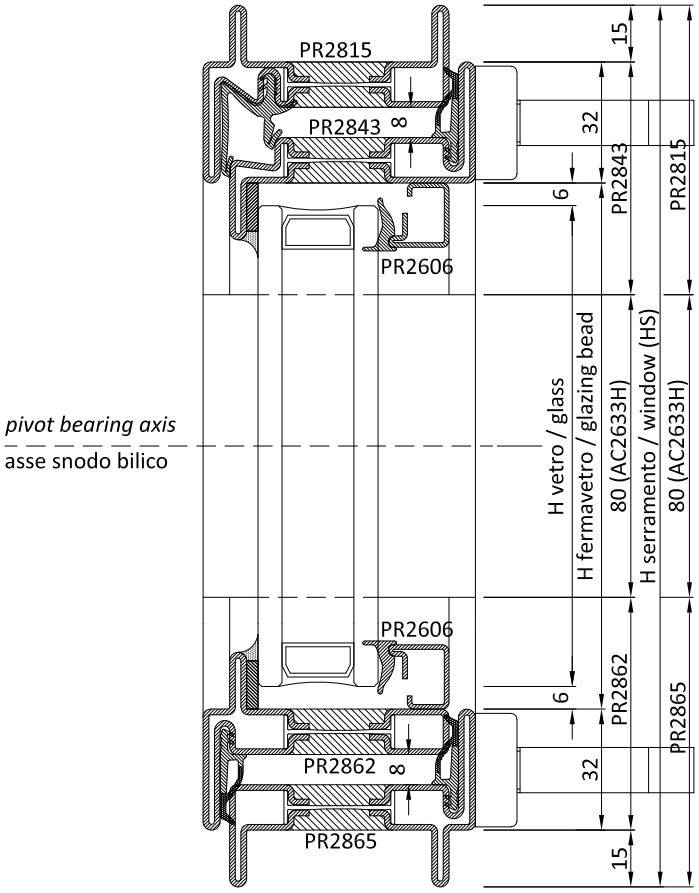


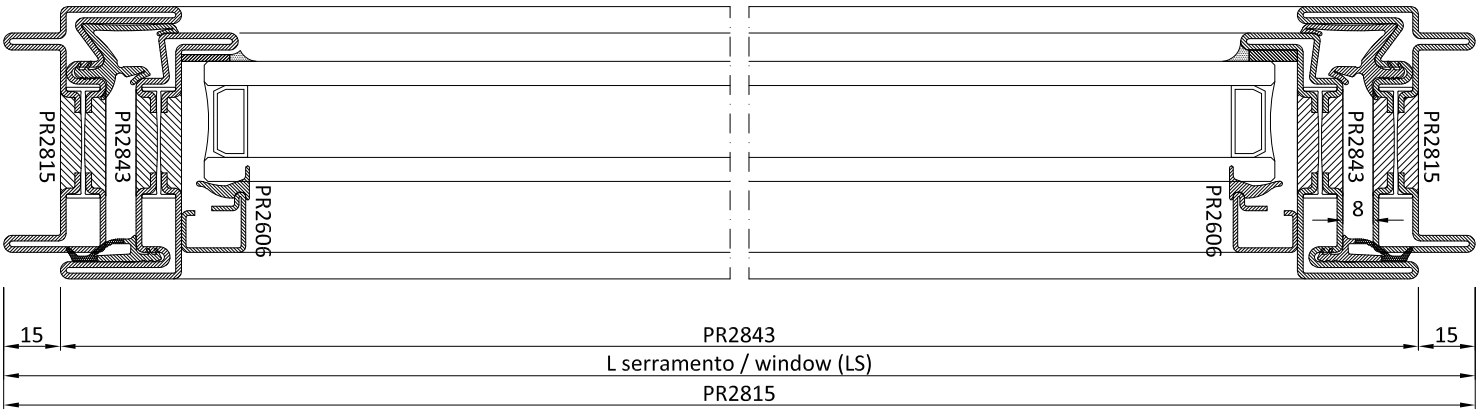
PROFILI *PROFILES*						
Codice *Code*	Descrizione *Descriprion*			Dim.	Taglio *Cutting*	
Telaio *Frame*						
PR2815	Profilo telaio	*Profile frame*	1	LS	45°	45°
PR2815	Profilo telaio	*Profile frame*	1	(HS-80)/2	90°	45°
PR2815	Profilo telaio	*Profile frame*	1	(HS-80)/2	45°	90°
PR2865	Profilo telaio	*Profile frame*	1	LS	45°	45°
PR2865	Profilo telaio	*Profile frame*	1	(HS-80)/2	45°	90°
PR2865	Profilo telaio	*Profile frame*	1	(HS-80)/2	90°	45°
Anta *Leaf*						
PR2843	Profilo anta	*Profile leaf*	1	LS-30	45°	45°
PR2843	Profilo anta	*Profile leaf*	1	(HS-110)/2	90°	45°
PR2843	Profilo anta	*Profile leaf*	1	(HS-110)/2	45°	90°
PR2862	Profilo anta	*Profile leaf*	1	LS-30	45°	45°
PR2862	Profilo anta	*Profile leaf*	1	(HS-110)/2	45°	90°
PR2862	Profilo anta	*Profile leaf*	1	(HS-110)/2	90°	45°
Fermavetri *Glazing beads*						
PR2606	Profilo fermavetro	*Glazing beads profile*	2	LS-94	45°	45°
PR2606	Profilo fermavetro	*Glazing beads profile*	2	HS-94	45°	45°
Vetri *Glass*						
	Vetro camera	*Double Glazing*	1	LS-106 x HS-106		

ACCESSORI *HARDWARE*				
Codice *Code*	Descrizione *Descriprion*			Dim.
AC2608	Clips fissaggio fermavetri	*Clips to secure glazing beads*	var.	
AC2617N	Guarnizione d'angolo	*Vulcanised corner gasket*	2	
AC2633H	Coppia snodi bilico	*Pivot bearing*	1	
AC2625 D/S	Kit cremonese apertura interna	*Inwards opening cremone bolt set*	1	
AC2683 D/S	Kit cremonese apertura esterna	*Outwards opening cremone bolt set*	1	
AC2626R	Kit per terza chiusura	*Three-point lock system kit*	var.	
AC2686	Braccetto limitatore apertura	*Casement opening stays*	1	
ACV 77..	Maniglie "Vitruvio"	*Handle " Vitruvio"*	2	
AC2803I*	Kit squadrette per PR2815	*Corner brackets kit for PR2815*	2	
AC2843I*	Kit squadrette per PR2843	*Corner brackets kit for PR2843*	2	
AC2862I*	Kit squadrette per PR2862	*Corner brackets kit for PR2862*	2	
AC2865I*	Kit squadrette per PR2865	*Corner brackets kit for PR2865*	2	
GUARNIZIONI *WEATHER STRIP*				
GE2645TT	Guarnizione di battuta	*Internal weather strip*	1	3xLS+3xHS
GE2603	Guarnizione giunto aperto	*Weather strip for open joint*	1	LS+HS
GU2036	Piattina adesiva fondo giunto	*Adhesive shim for joint*	1	2xLS+2xHS
GP0095	Guarnizione interna vetro	*Internal weather strip*	1	2xLS+2xHS

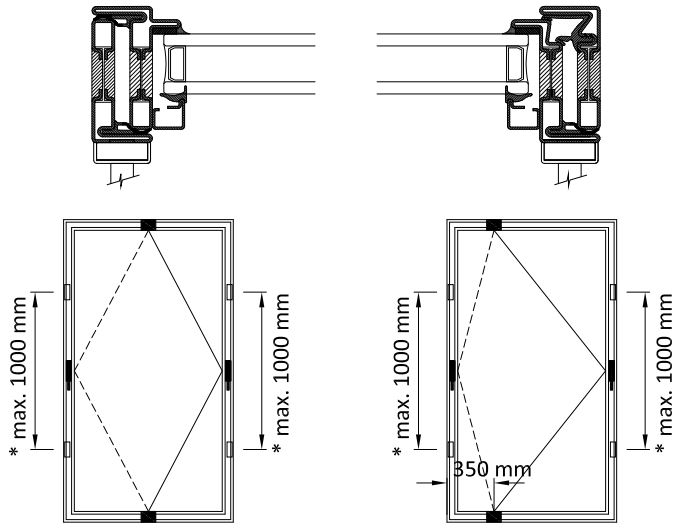
* solo con profili ottone | *only with brass profiles*

N.B.: le dimensioni delle guarnizioni sono indicative e devono essere aumentate del 10% per adattamenti e ritiri del materiale nel tempo
Attention: the gasket dimensions are indicative and have to be increased by 10% owing to adaptation and contractions of the material over time

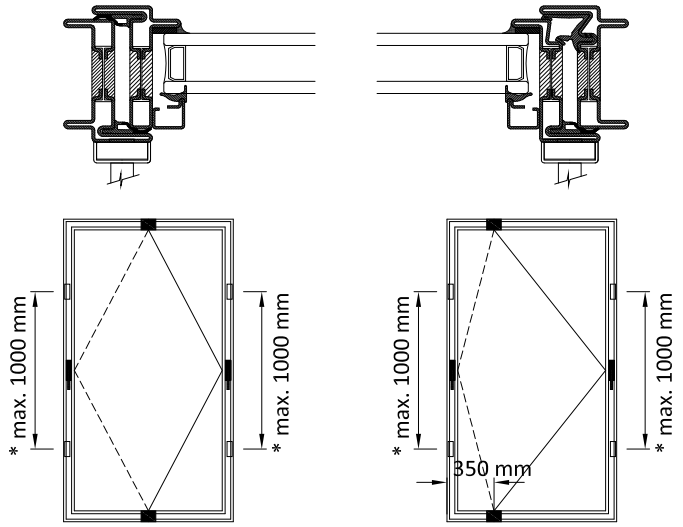

PR2815
PR2843
8
PR2606
PR2606
PR2862
8
PR2865
pivot bearing axis
asse snodo bilico
15
32
6
6
32
15
PR2843
PR2815
80 (AC2633H)
80 (AC2633H)
PR2862
PR2865
H vetro / glass
H fermavetro / glazing bead
H serramento / window (HS)


PR2815
PR2843
PR2606
PR2606
PR2843
8
PR2815
15
PR2843
15
L serramento / window (LS)
PR2815

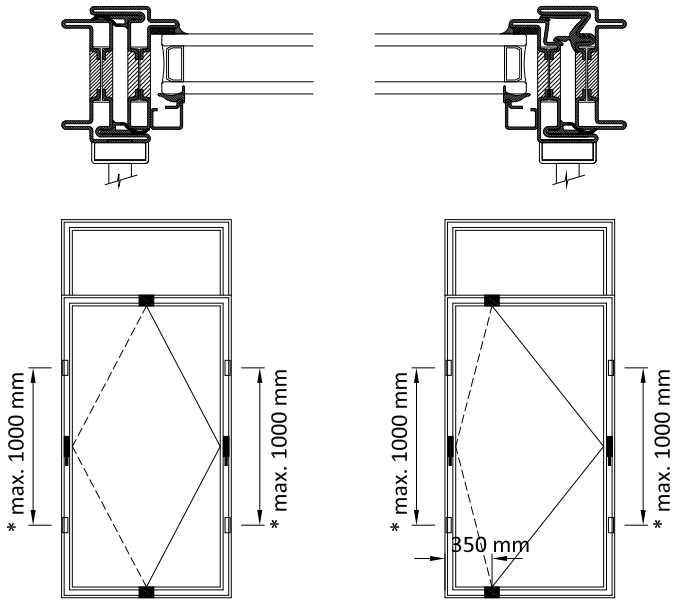

PR2865
PR2862
PR2606
PR2606
PR2862
PR2865
6
6
L vetro / glass
32
L fermavetro / glazing bead
32
15
PR2862
15
L serramento / window (LS)
PR2865



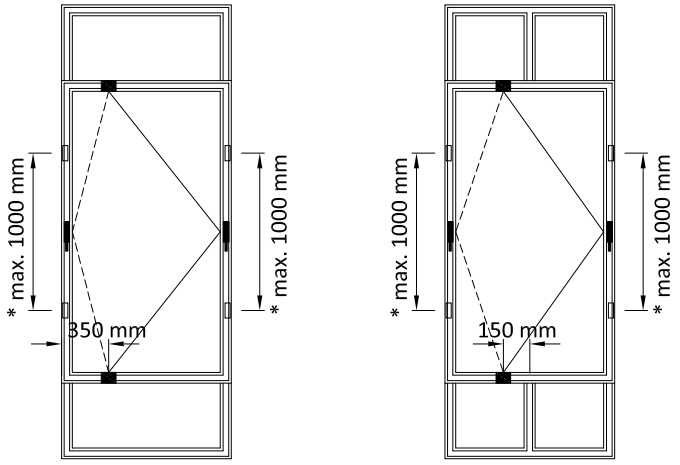
Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura apertura interna *Cremone bolt set inwards opening*	4.3.7 4.5.2-3
AC2683 D/S	Kit cremonese chiusura apertura esterna *Cremone bolt set outwards opening*	4.3.8-9 4.5.4-5
AC2633SV	Snodo bilico *Pivot bearing*	4.3.12|15 4.4.8|9 - 5.1.5
AC2626 R	Chiusura supplementare *Additional lock*	4.3.10|11 4.5.6



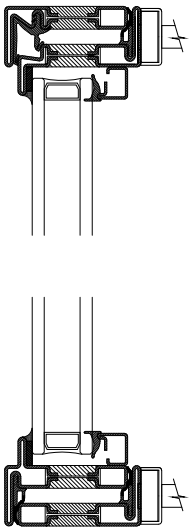
Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura apertura interna *Cremone bolt set inwards opening*	4.3.7 4.5.2-3
AC2683 D/S	Kit cremonese chiusura apertura esterna *Cremone bolt set outwards opening*	4.3.8-9 4.5.4-5
AC2633V	Snodo bilico *Pivot bearing*	4.3.12|15 4.4.6|7 - 5.1.5
AC2626 R	Chiusura supplementare *Additional lock*	4.3.10|11 4.5.6

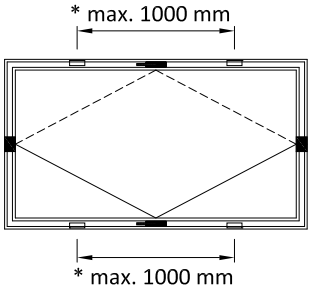


Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura apertura interna *Cremone bolt set inwards opening*	4.3.7 4.5.2-3
AC2683 D/S	Kit cremonese chiusura apertura esterna *Cremone bolt set outwards opening*	4.3.8-9 4.5.4-5
AC2637V	Snodo bilico *Pivot bearing*	4.3.12|15 4.4.10|11 - 5.1.5
AC2626 R	Chiusura supplementare *Additional lock*	4.3.10|11 4.5.6

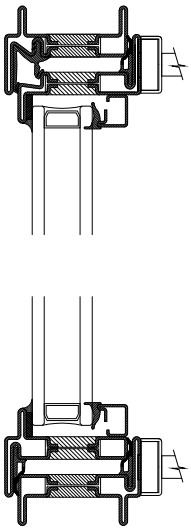


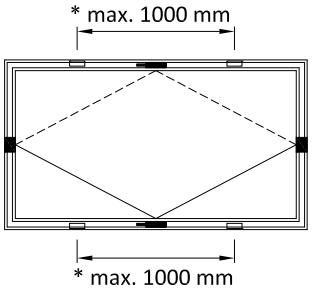
Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura apertura interna *Cremone bolt set inwards opening*	4.3.7 4.5.2-3
AC2683 D/S	Kit cremonese chiusura apertura esterna *Cremone bolt set outwards opening*	4.3.8-9 4.5.4-5
AC2638V	Snodo bilico *Pivot bearing*	4.3.12|15 4.4.12|13 - 5.1.5
AC2626 R	Chiusura supplementare *Additional lock*	4.3.10|11 4.5.6



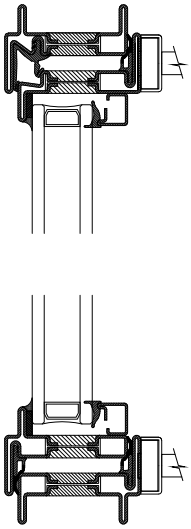


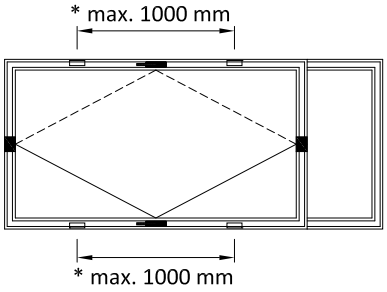
Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura apertura interna *Cremone bolt set inwards opening*	4.3.7 4.5.2-3
AC2683 D/S	Kit cremonese chiusura apertura esterna *Cremone bolt set outwards opening*	4.3.8-9 4.5.4-5
AC2633SH	Snodo bilico *Pivot bearing*	4.3.12|15 4.4.8|9 - 5.1.5
AC2626 R	Chiusura supplementare *Additional lock*	4.3.10|11 4.5.6



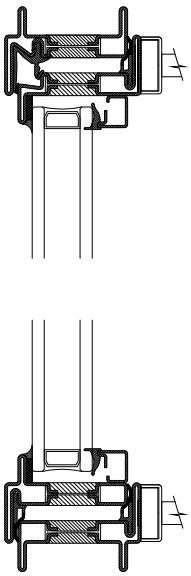


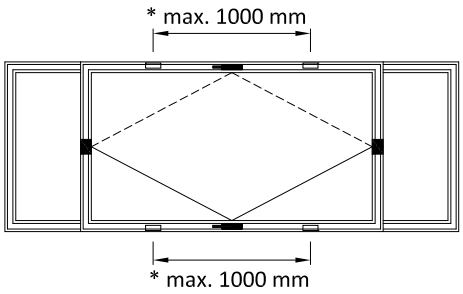
Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura apertura interna *Cremone bolt set inwards opening*	4.3.7 4.5.2-3
AC2683 D/S	Kit cremonese chiusura apertura esterna *Cremone bolt set outwards opening*	4.3.8-9 4.5.4-5
AC2633H	Snodo bilico *Pivot bearing*	4.3.12|15 4.4.6|7 - 5.1.5
AC2626 R	Chiusura supplementare *Additional lock*	4.3.10|11 4.5.6



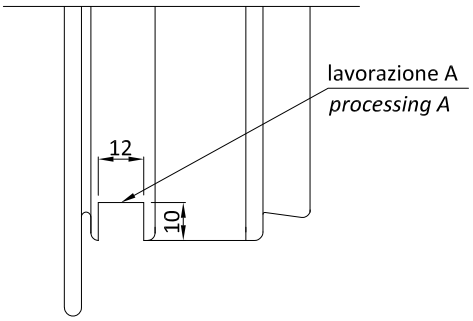


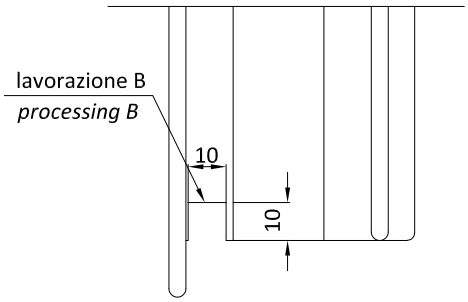
Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura apertura interna *Cremone bolt set inwards opening*	4.3.7 4.5.2-3
AC2683 D/S	Kit cremonese chiusura apertura esterna *Cremone bolt set outwards opening*	4.3.8-9 4.5.4-5
AC2637H	Snodo bilico *Pivot bearing*	4.3.12|15 4.4.10|11 - 5.1.5
AC2626 R	Chiusura supplementare *Additional lock*	4.3.10|11 4.5.6





Art. *Code*	Descrizione *Description*	Pag.
AC2625 D/S	Kit cremonese chiusura apertura interna *Cremone bolt set inwards opening*	4.3.7 4.5.2-3
AC2683 D/S	Kit cremonese chiusura apertura esterna *Cremone bolt set outwards opening*	4.3.8-9 4.5.4-5
AC2638H	Snodo bilico *Pivot bearing*	4.3.12|15 4.4.12|13 - 5.1.5
AC2626 R	Chiusura supplementare *Additional lock*	4.3.10|11 4.5.6


lavorazione A
processing A
12
10


lavorazione B
processing B
10
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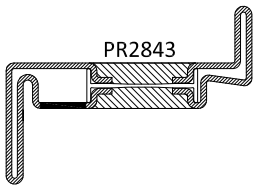
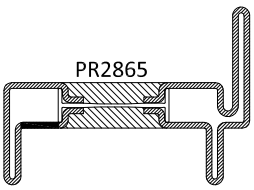
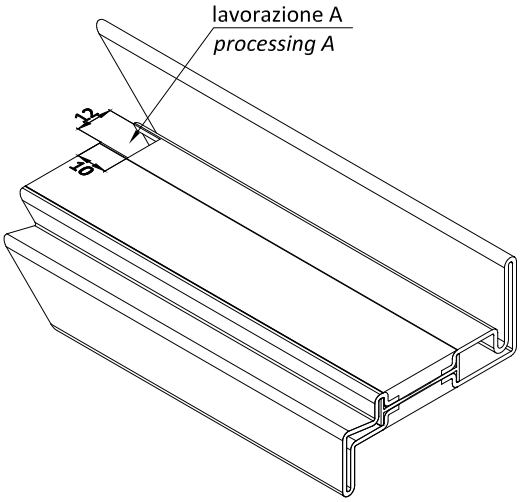
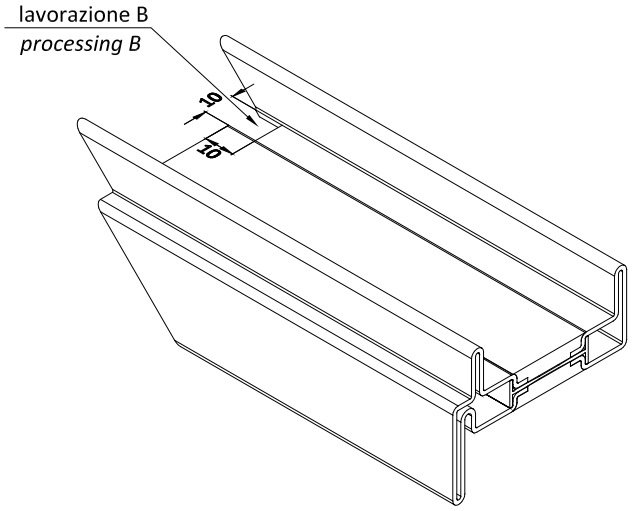
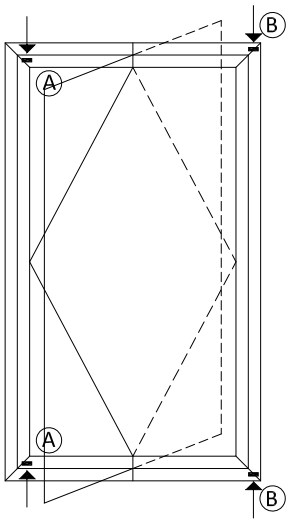
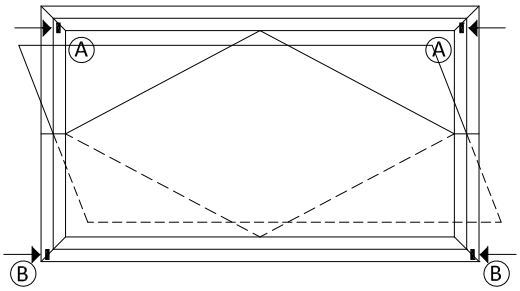

PR2843

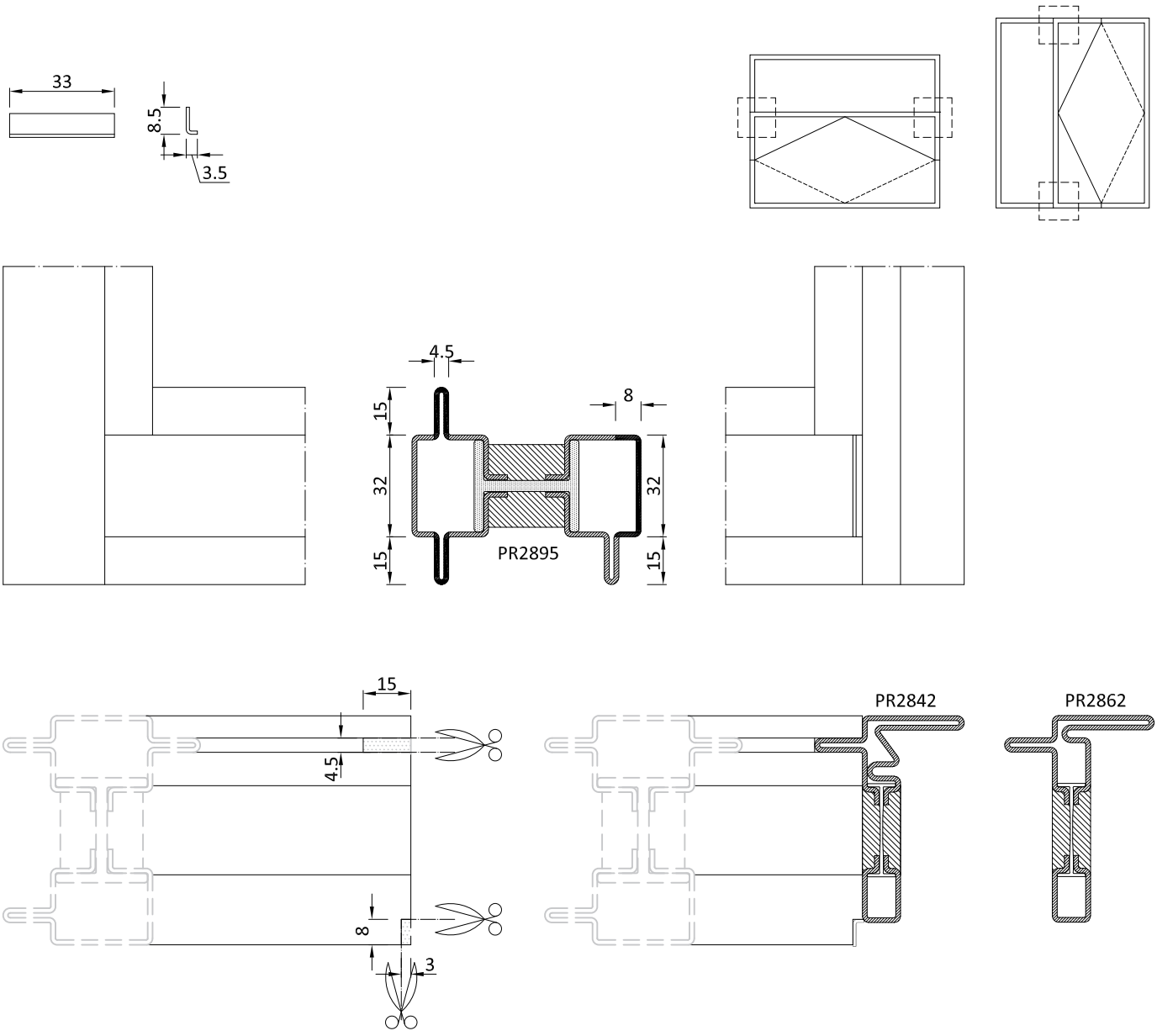

PR2865

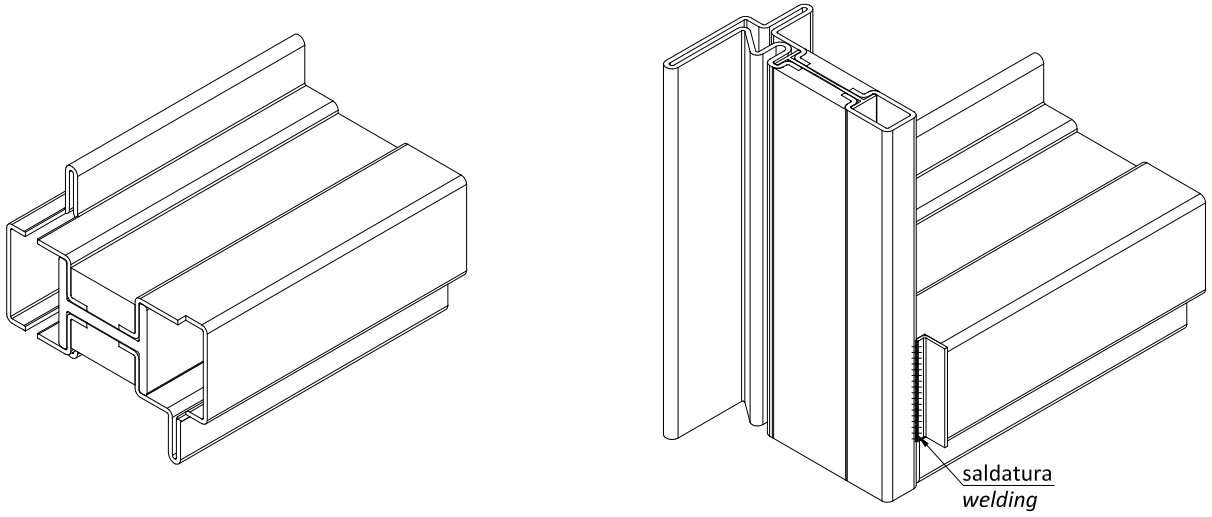

lavorazione A
processing A
12
10


lavorazione B
processing B
10
10

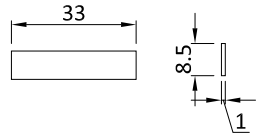

A
B
A
B

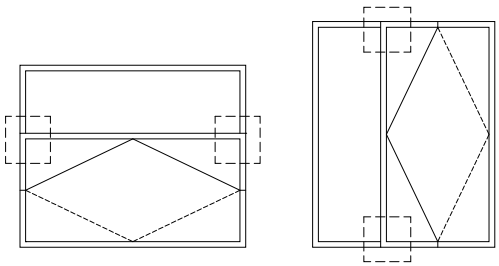

A
A
B
B

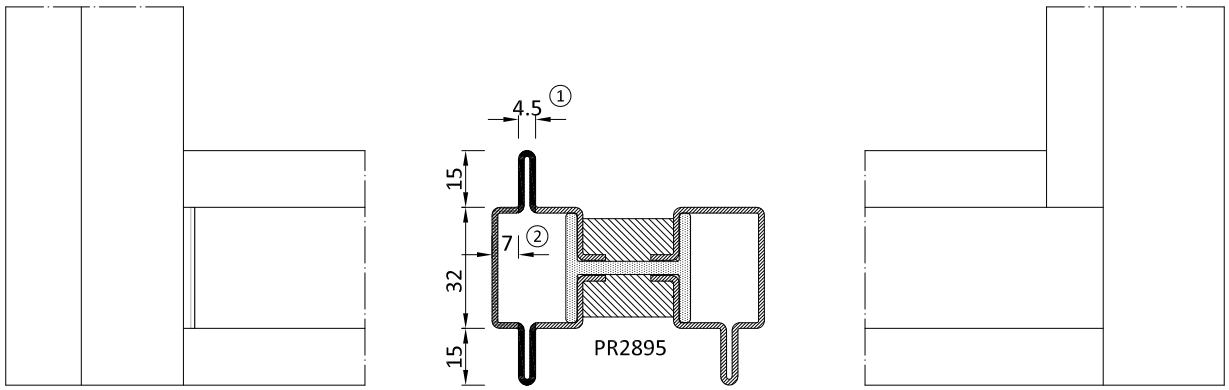


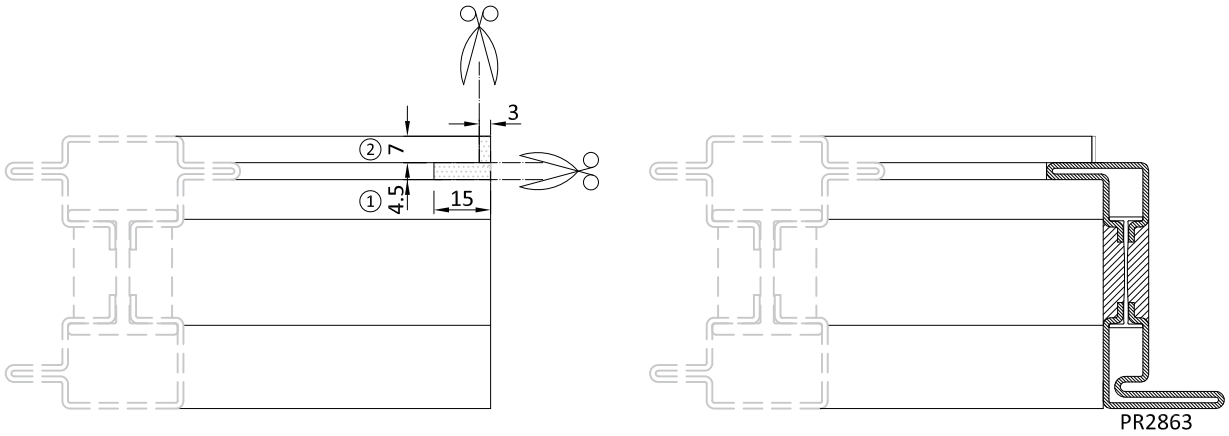


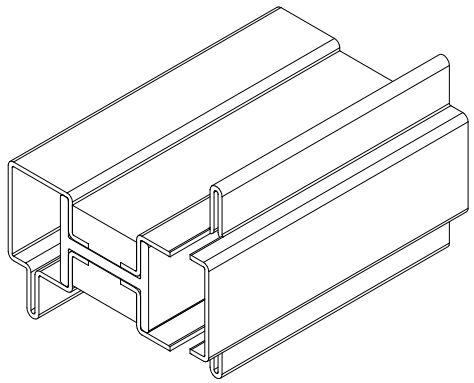
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

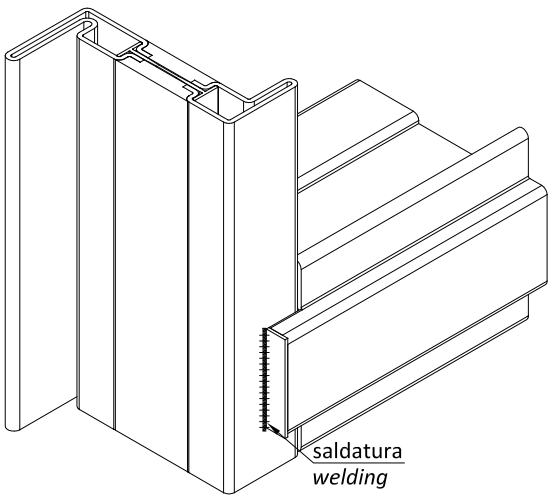




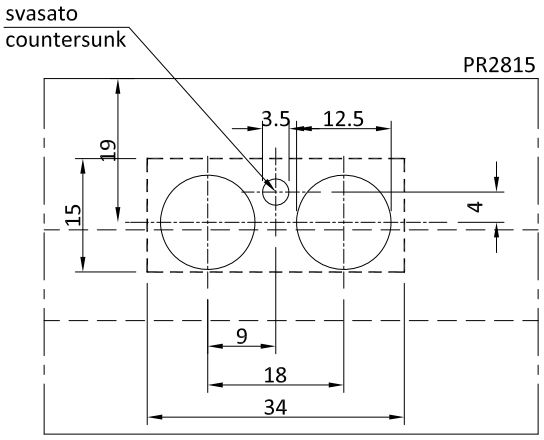


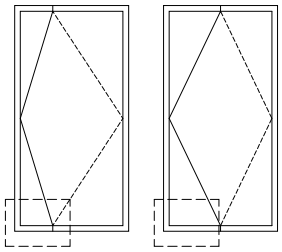




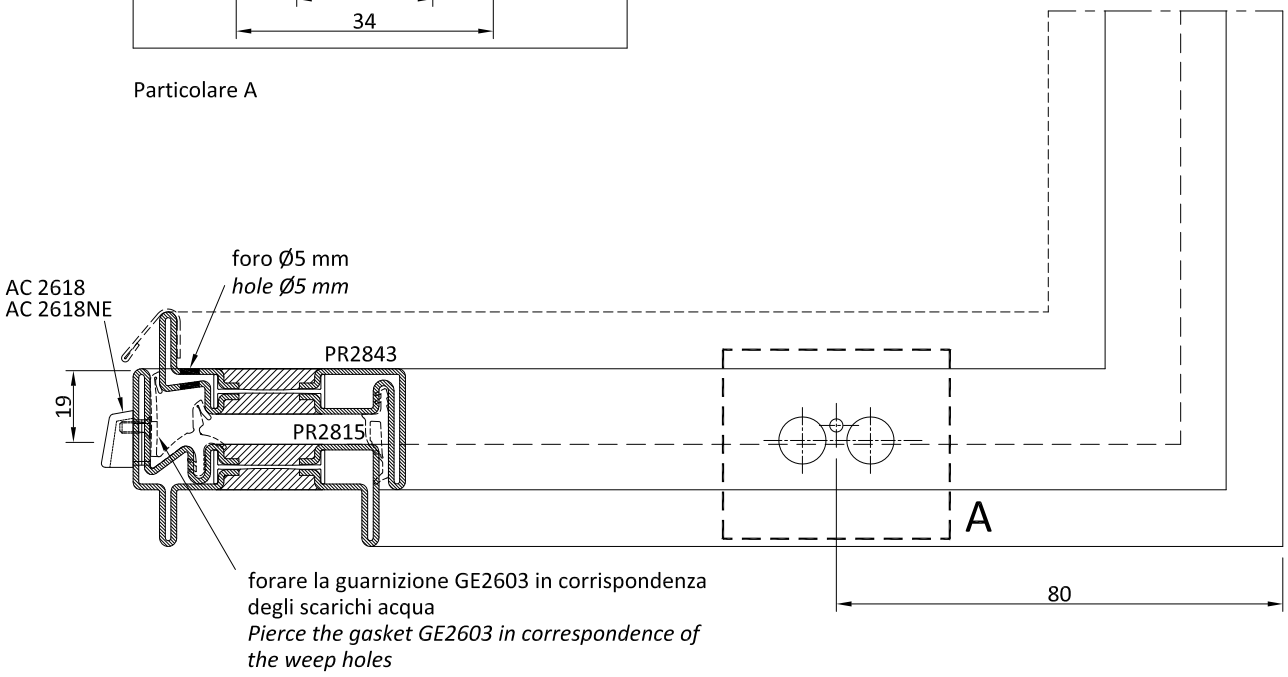


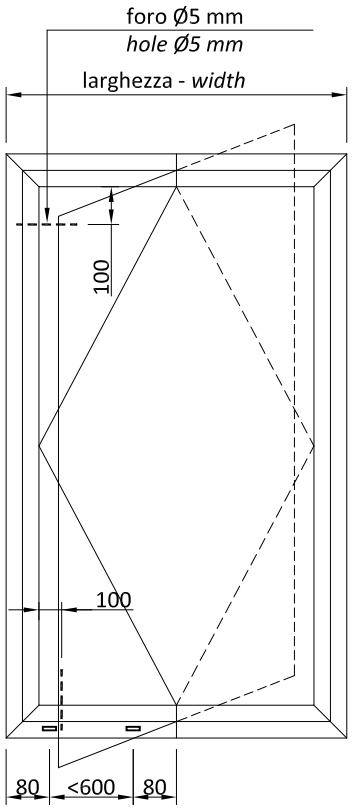
Nota: i fondini sono forniti di dimensioni maggiori da rifilare dopo la saldatura
Note: *the fitting are provided larger by trimming after welding*

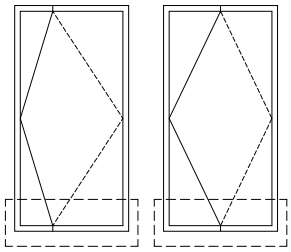


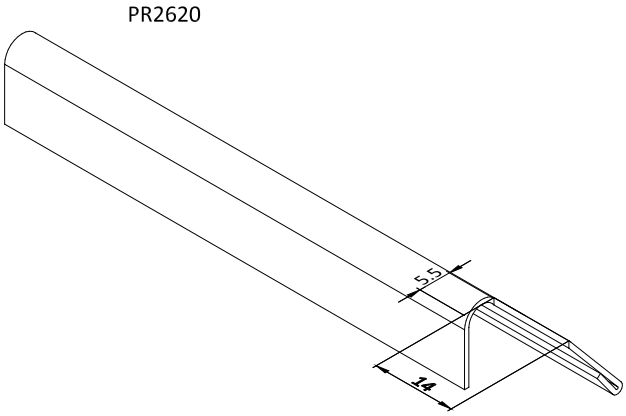


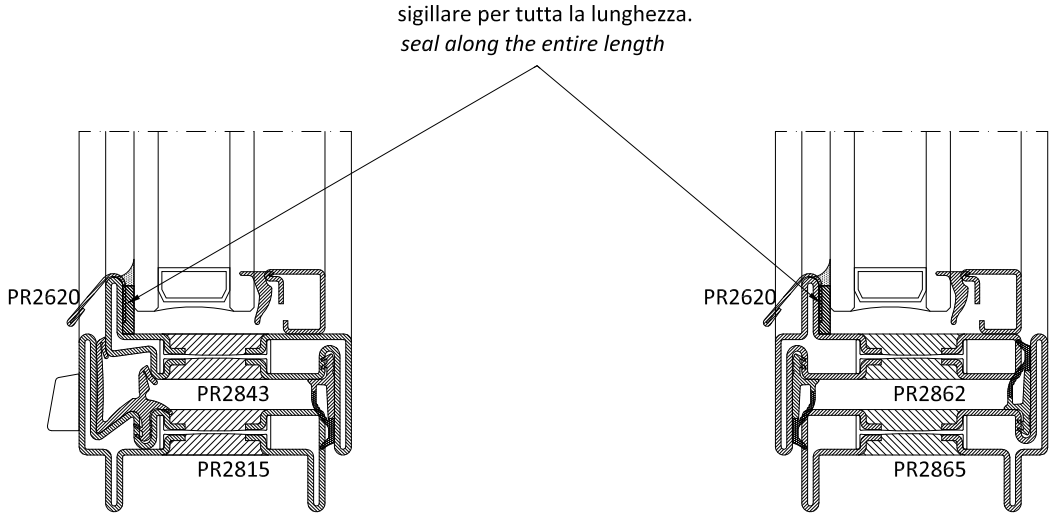
Particolare A

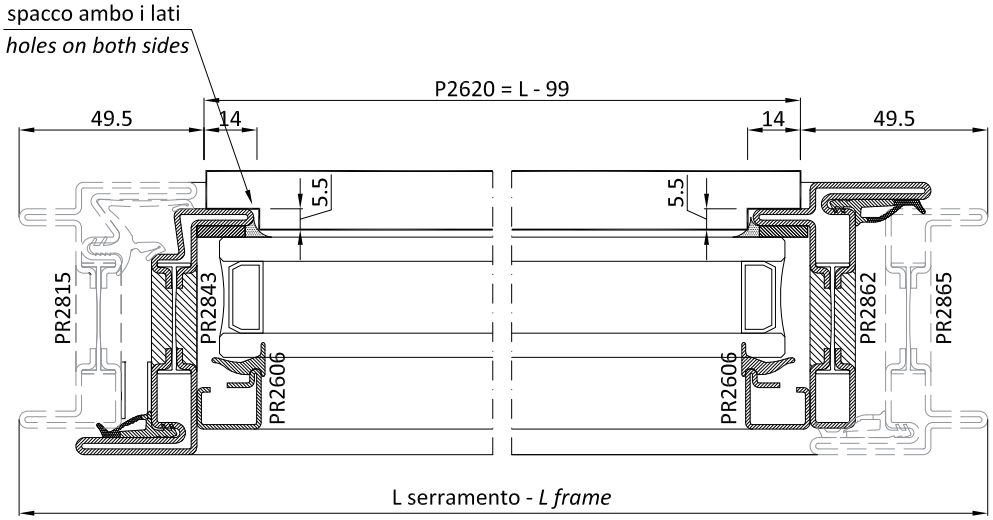


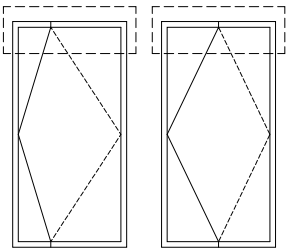


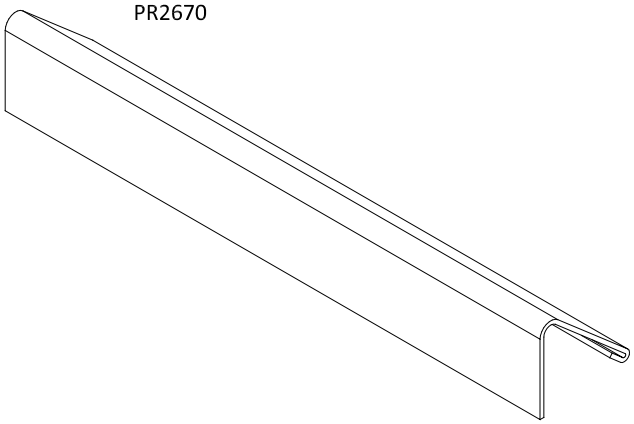


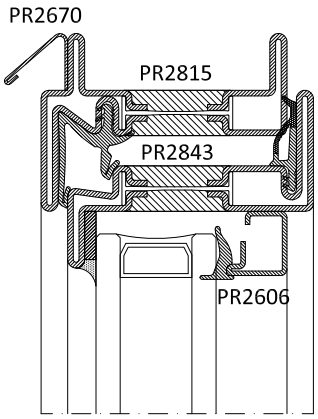

PR2620
5.5
14

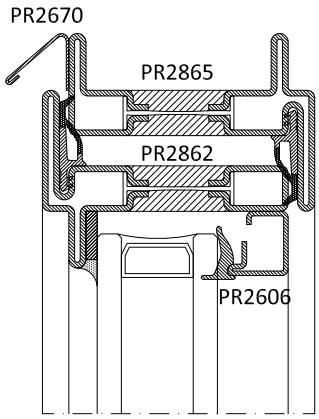

sigillare per tutta la lunghezza.
seal along the entire length
PR2620
PR2843
PR2815
PR2620
PR2862
PR2865

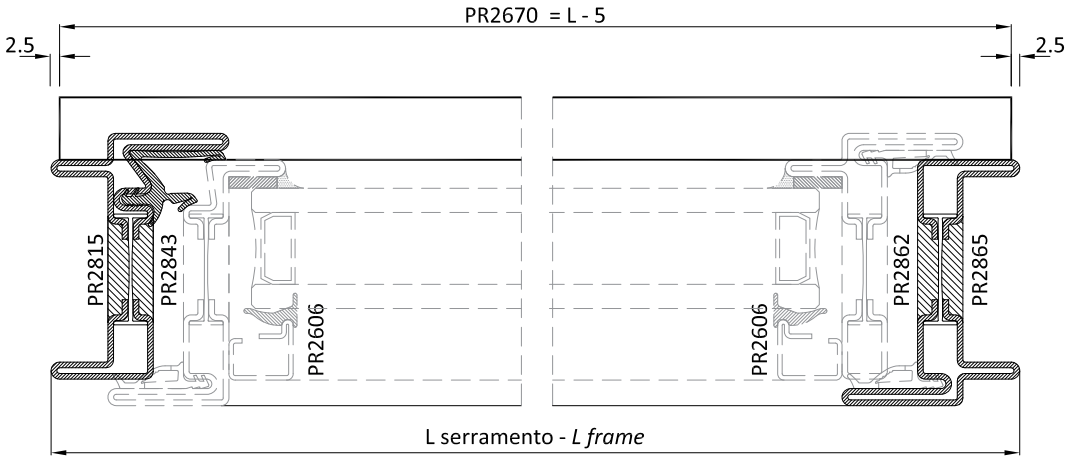

spacco ambo i lati
holes on both sides
P2620 = L - 99
49.5
14
14
49.5
5.5
5.5
PR2815
PR2843
PR2606
PR2606
PR2862
PR2865
L serramento - *L frame*

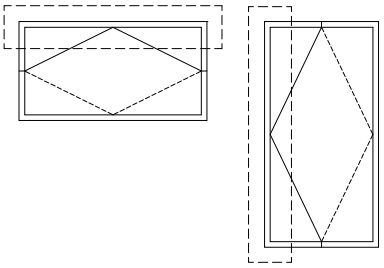


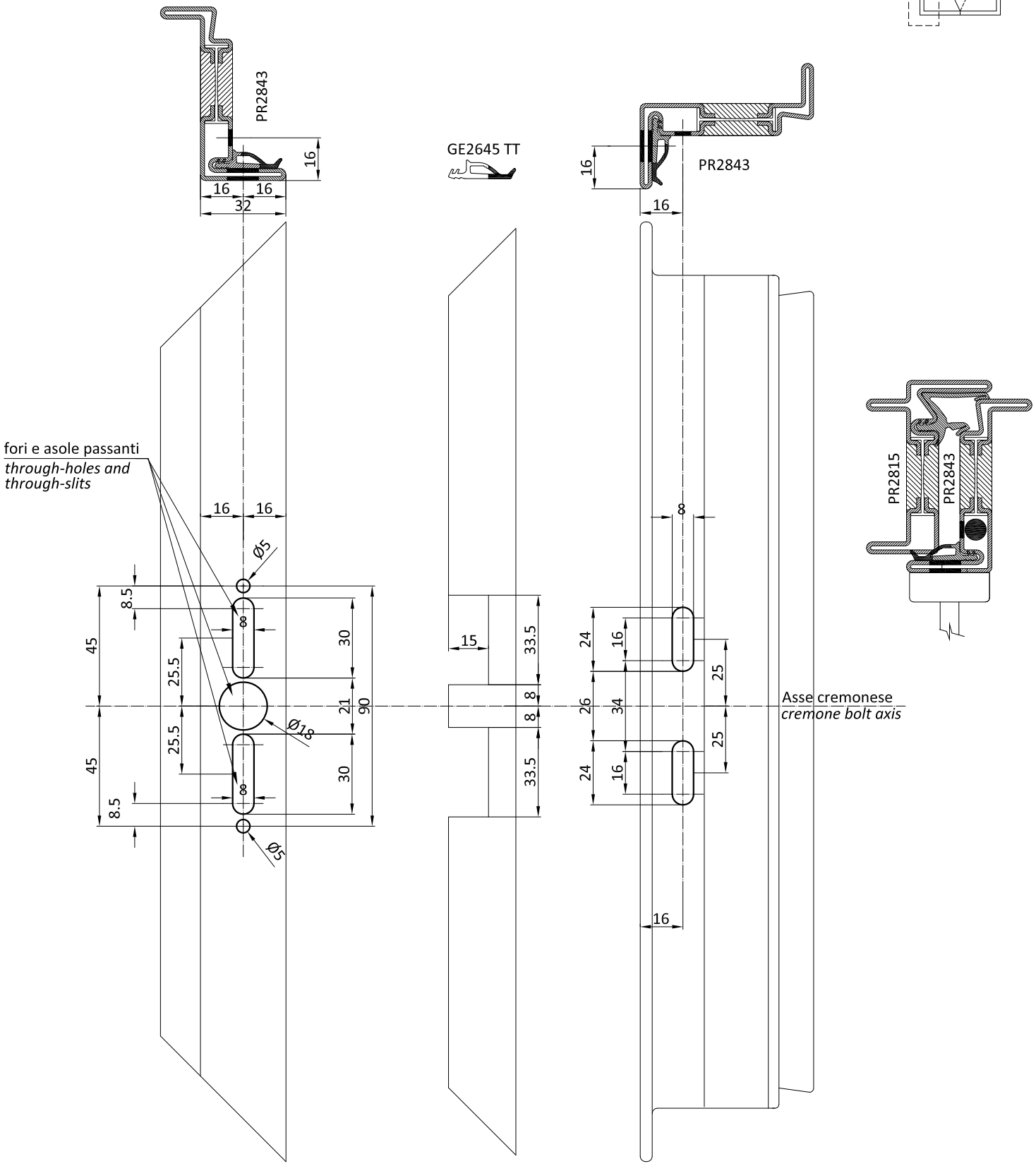

PR2670

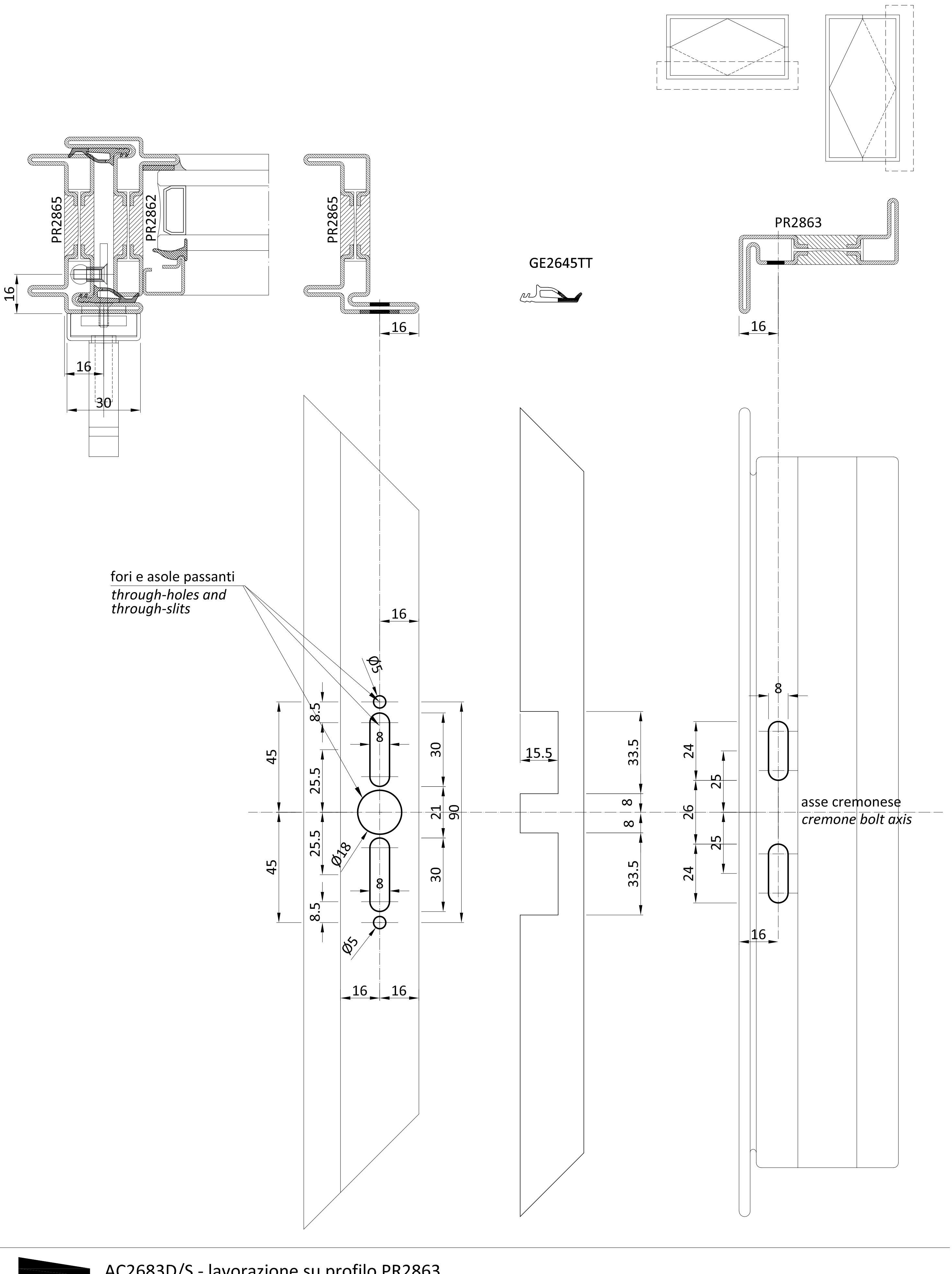

PR2670
PR2815
PR2843
PR2606


PR2670
PR2865
PR2862
PR2606

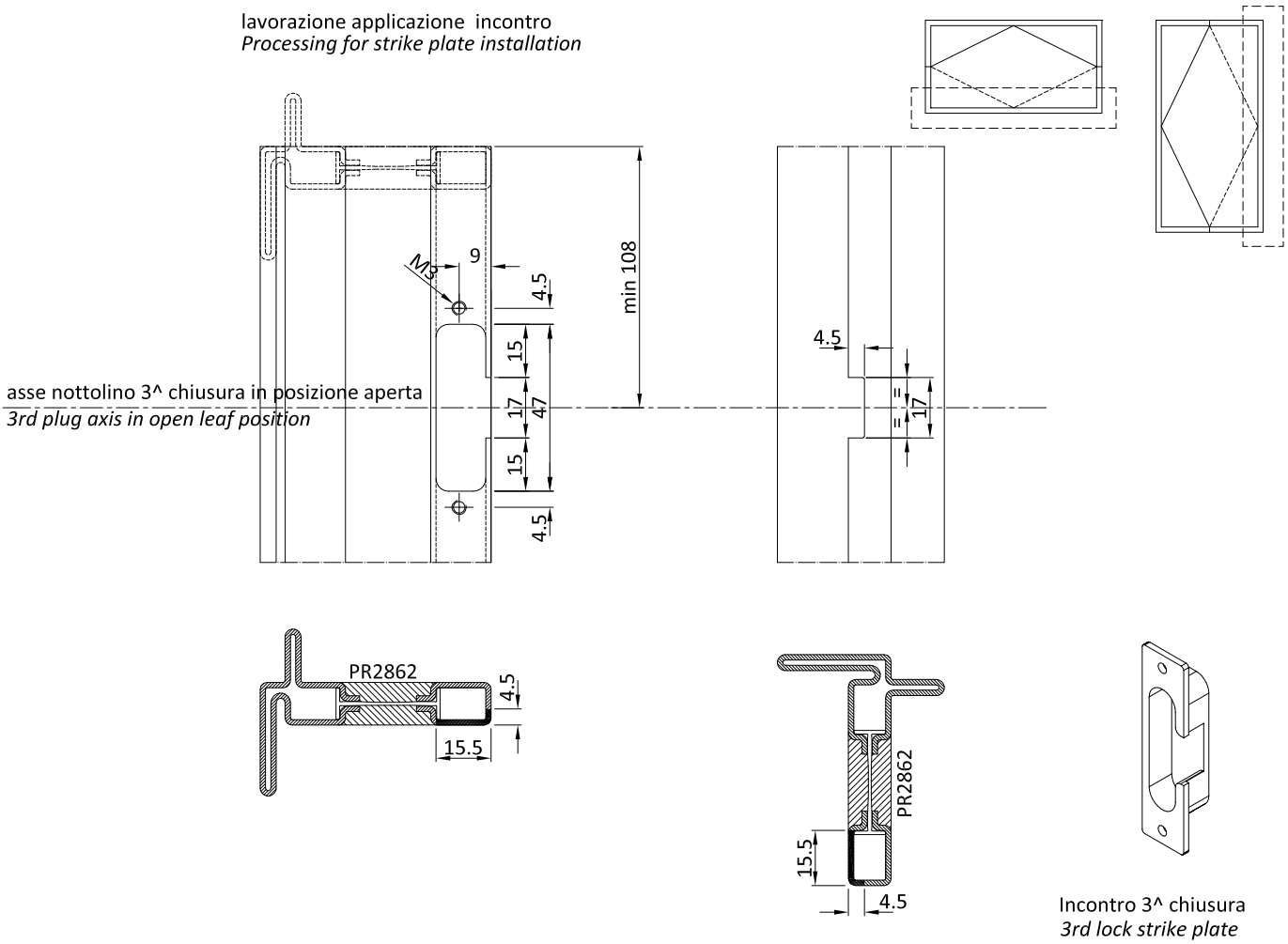

PR2670 = L - 5
2.5
2.5
PR2815
PR2843
PR2606
PR2606
PR2862
PR2865
L serramento - *L frame*




PR2843
16
16
16
32
GE2645 TT
16
PR2843
16
PR2815
PR2843
fori e asole passanti
through-holes and through-slits
16
16
Ø5
8.5
45
25.5
25.5
45
8.5
8
30
21
90
30
Ø18
Ø5
15
33.5
8
8
33.5
8
24
16
26
34
24
16
25
25
Asse cremonese
cremone bolt axis
16

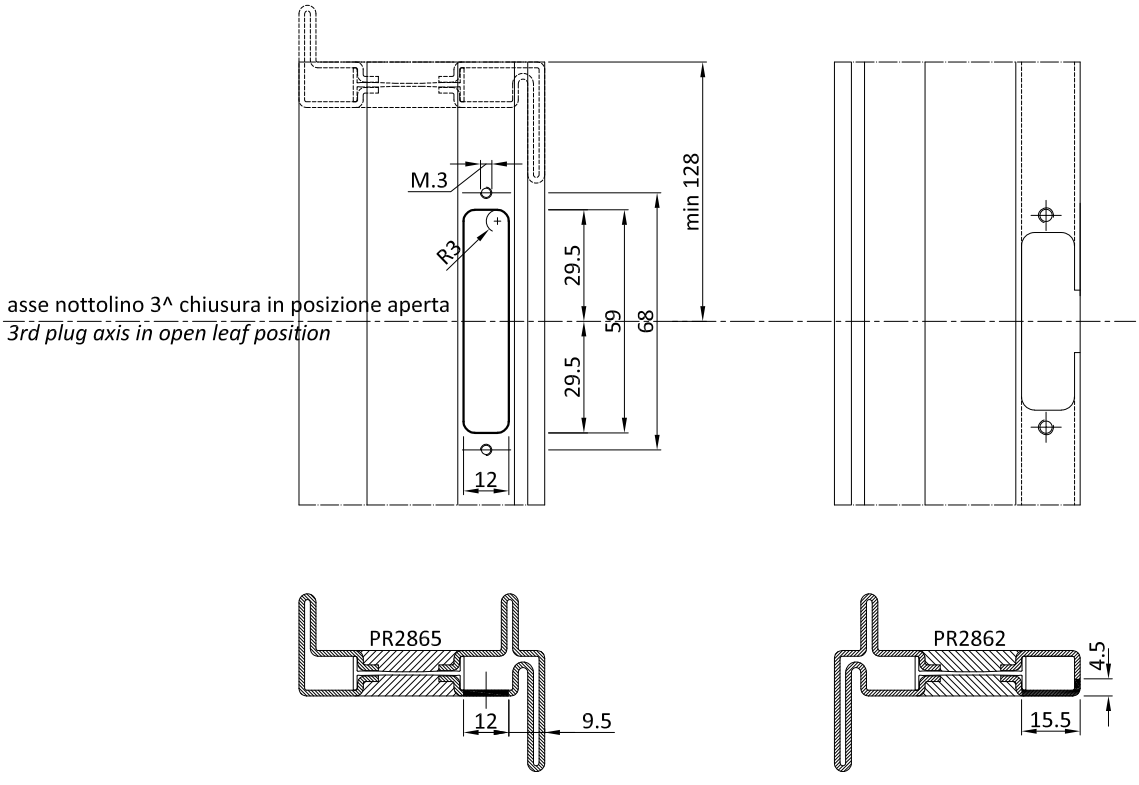

PR2865
PR2862
PR2865
PR2863
GE2645TT
16
16
30
16
16
fori e asole passanti
through-holes and through-slits
16
Ø5
8.5
8
45
25.5
30
21
90
Ø18
25.5
45
30
8
8.5
Ø5
16
16
15.5
33.5
8
8
33.5
8
24
25
26
25
24
asse cremonese
cremone bolt axis
16

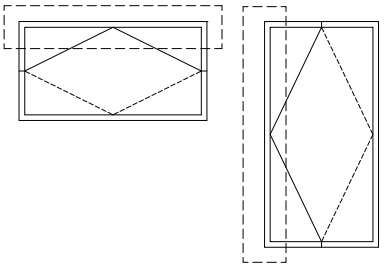
lavorazione applicazione incontro
Processing for strike plate installation



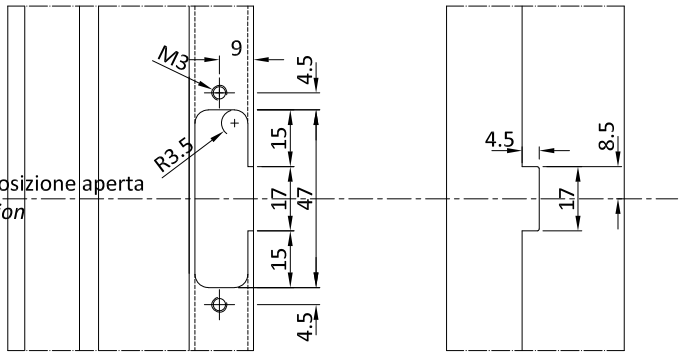
Incontro 3^ chiusura
3rd lock strike plate

lavorazione applicazione nottolino
Processing for plug installation

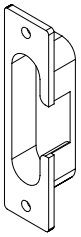




lavorazione applicazione incontro
Processing for the installation of the strike plate



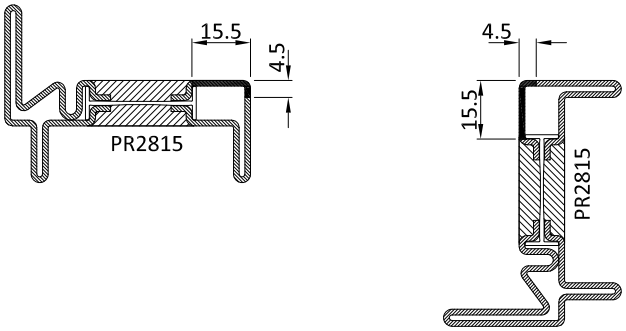
asse nottolino 3^ chiusura in posizione aperta
3rd plug axis in open leaf position



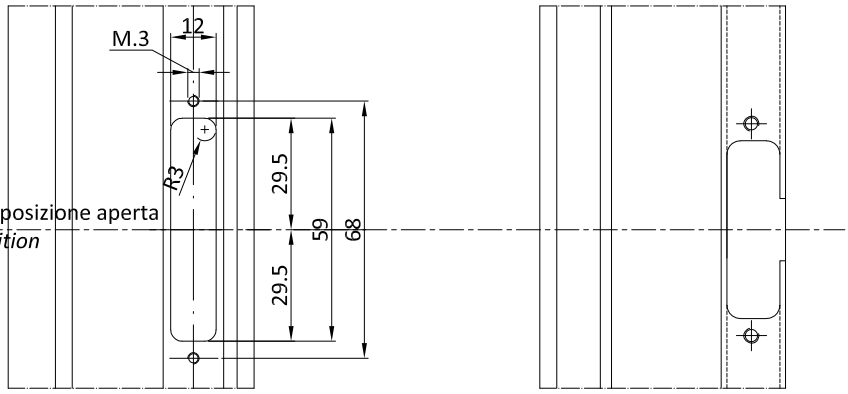
Incontro 3^ chiusura
3rd lock strike plate

N.B.: Distanza massima tra i punti di chiusura 1000 mm

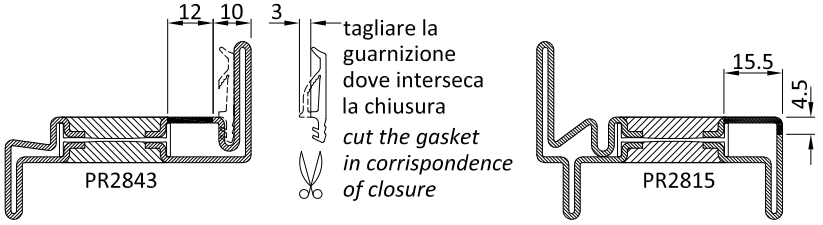
N.B.: Distance between the closing points max. 1000 mm



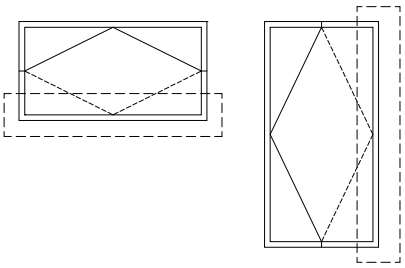
lavorazione applicazione nottolino
Processing for plug installation



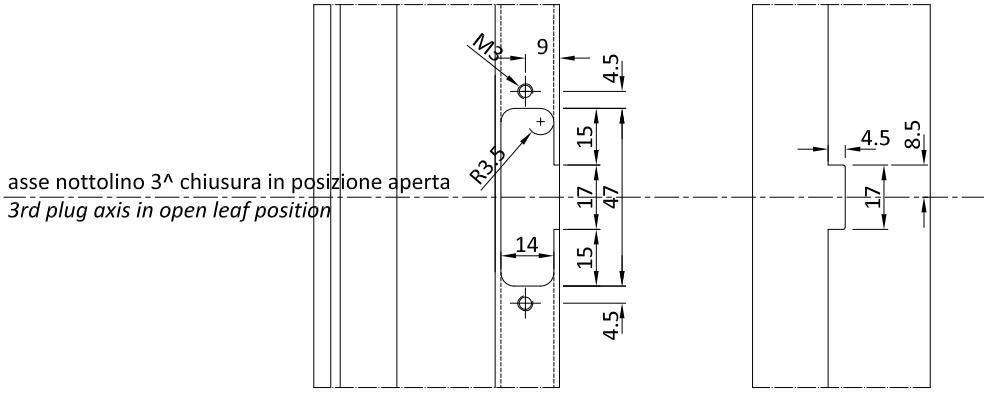
asse nottolino 3^ chiusura in posizione aperta
3rd plug axis in open leaf position

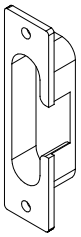


tagliare la guarnizione dove interseca la chiusura
cut the gasket in corrispondence of closure



lavorazione applicazione incontro
Processing for the installation of the strike plate

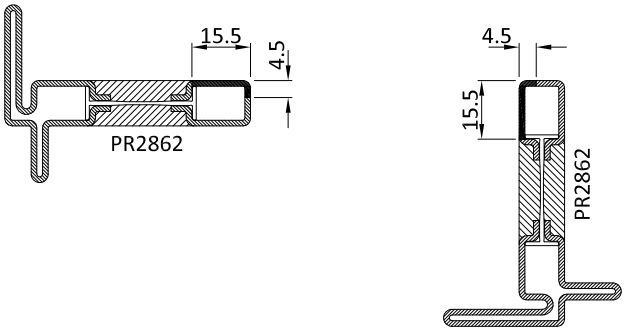




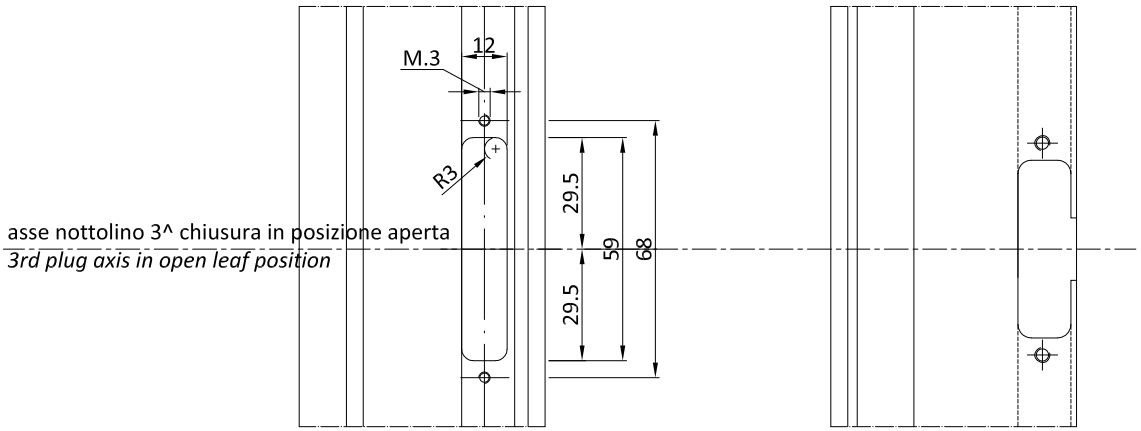
Incontro 3^ chiusura
3rd lock strike plate

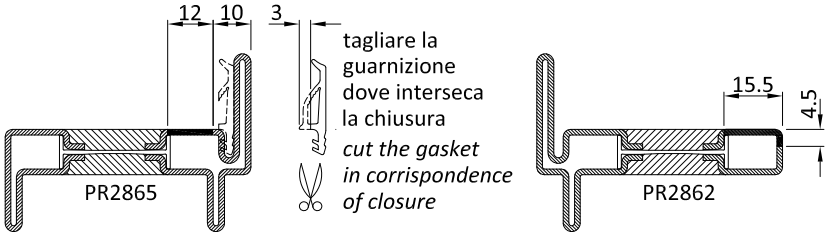
N.B.: Distanza massima tra i punti di chiusura 1000 mm

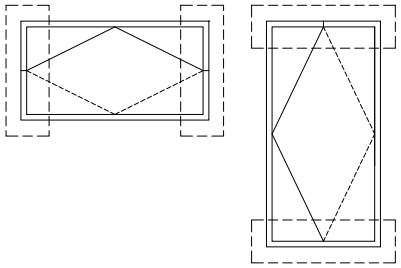
N.B.: Distance between the closing points max. 1000 mm

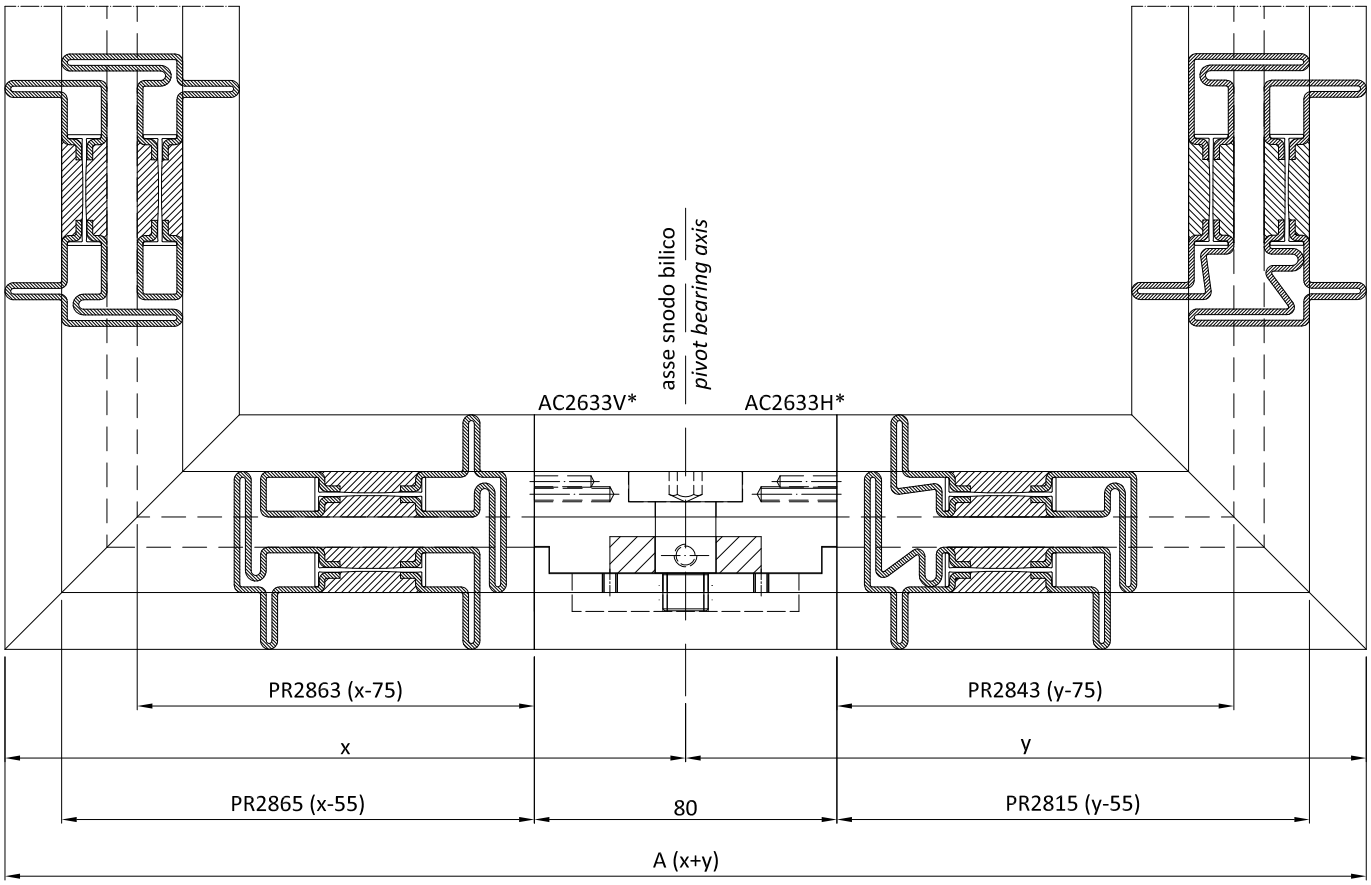


lavorazione applicazione nottolino
Processing for plug installation



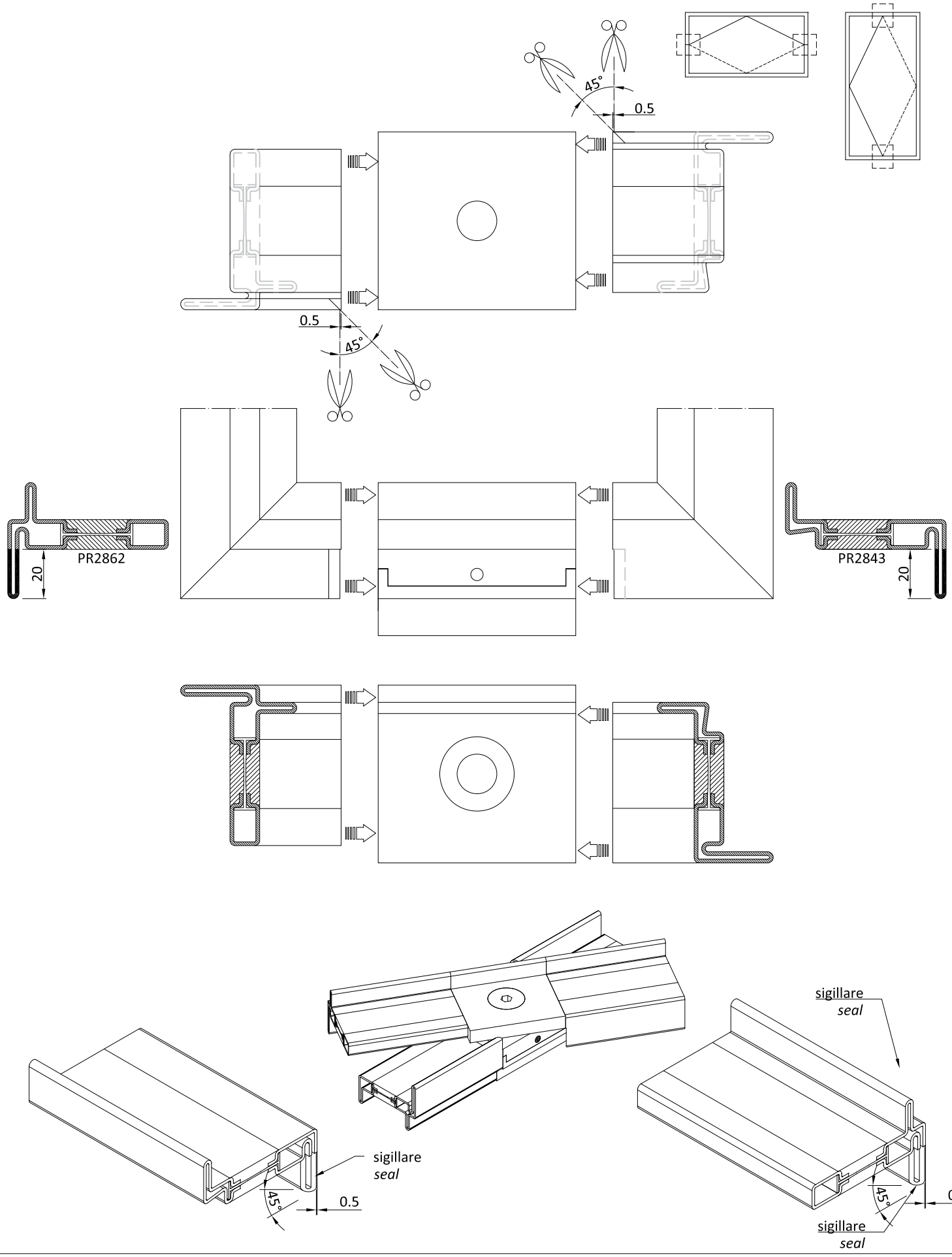


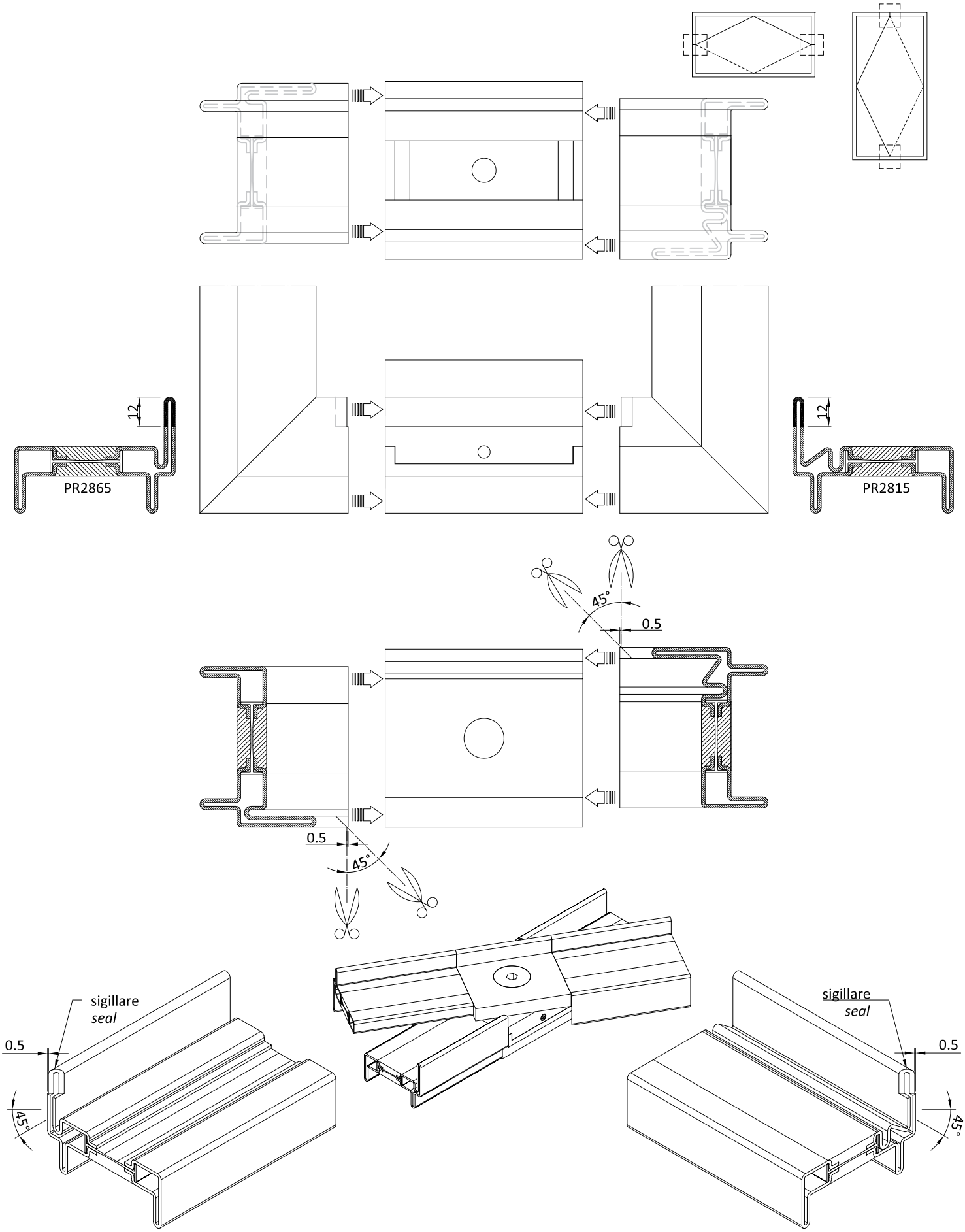


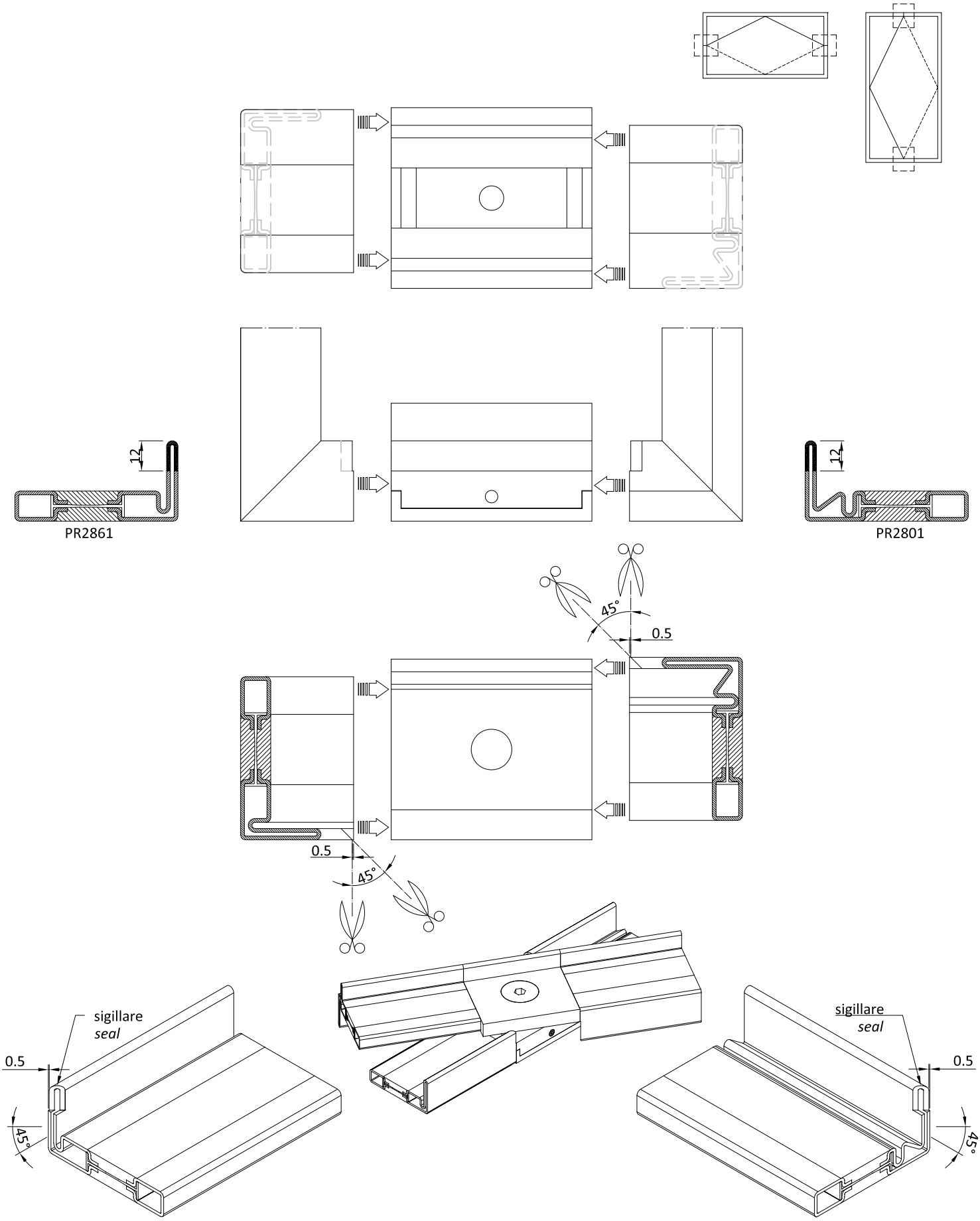


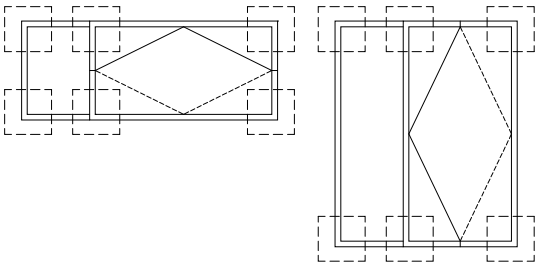
* Indicazioni valide anche per soluzione con partizioni fisse superiori e inferiori
(AC2633SV - AC2637V - AC2638V - AC2633SH - AC2637H - AC2638H)

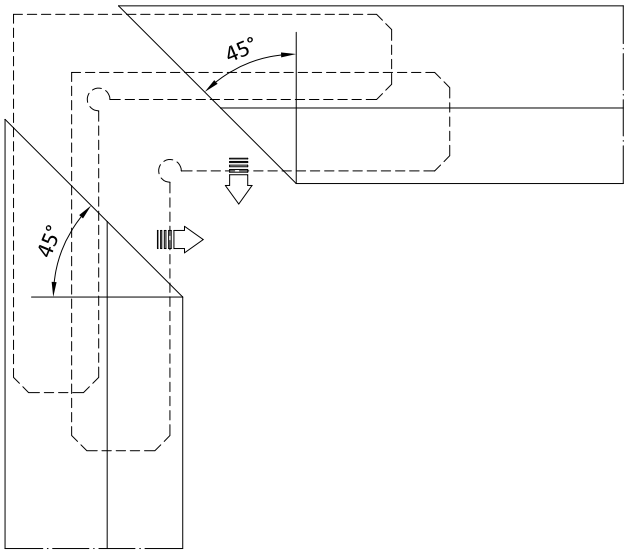
** Instruction valid also for the solution with upper and bottom fixed frames*
(AC2633SV - AC2637V - AC2638V - AC2633SH - AC2637H - AC2638H)


45°
0.5
0.5
45°
PR2862
20
PR2843
20
sigillare
seal
45°
0.5
sigillare
seal
sigillare
seal
45°
0.5


12
PR2865
12
PR2815
45°
0.5
0.5
45°
sigillare
seal
0.5
45°
sigillare
seal
0.5
45°

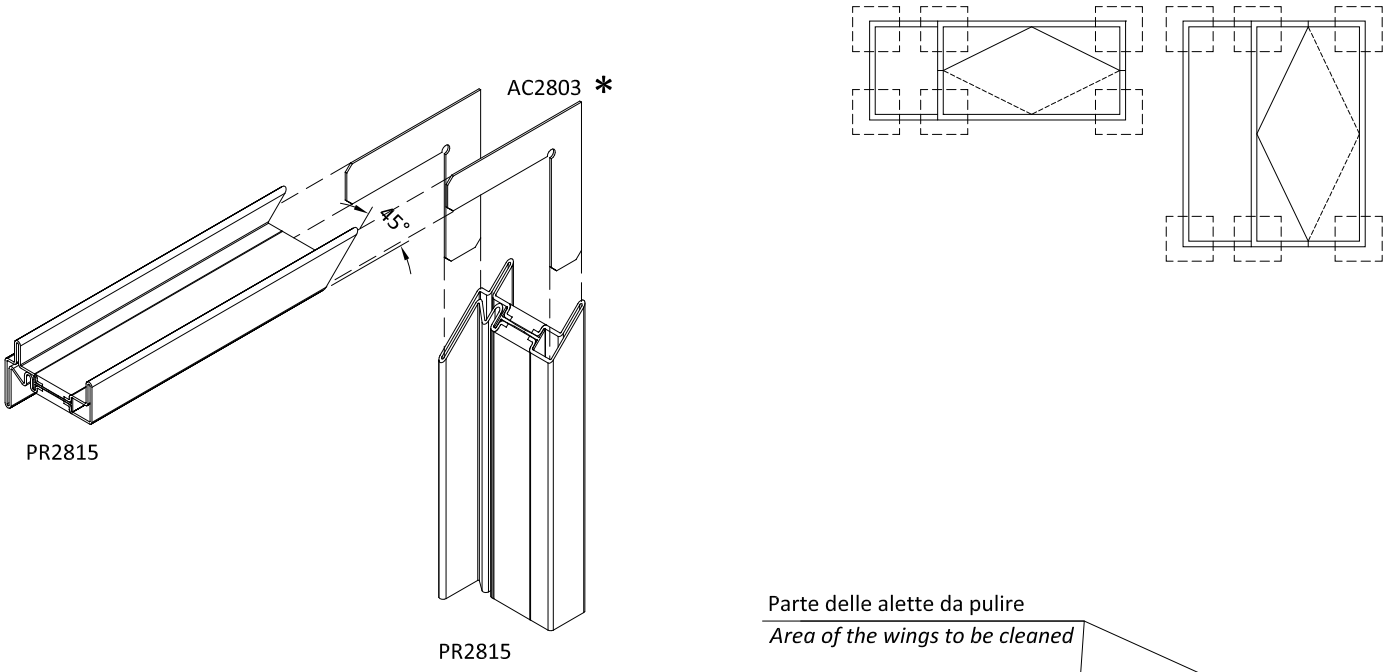

12
PR2861
12
PR2801
45°
0.5
0.5
45°
sigillare
seal
0.5
45°
sigillare
seal
0.5
45°

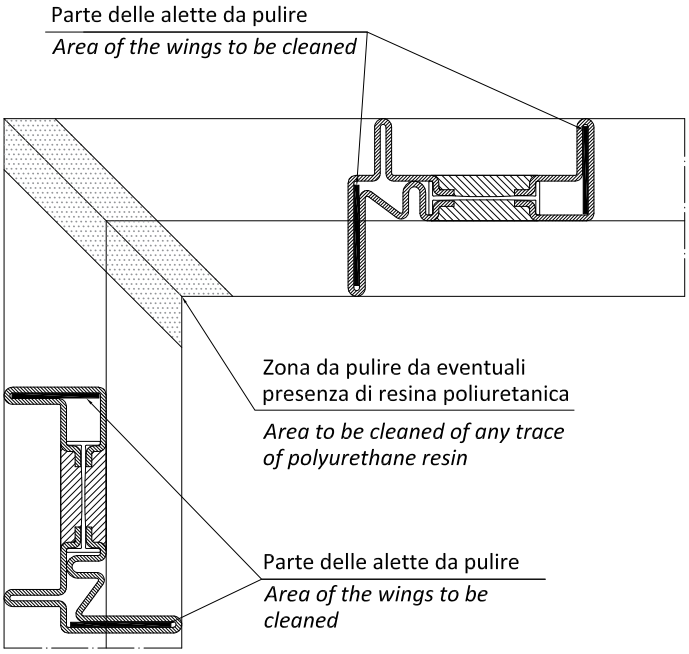


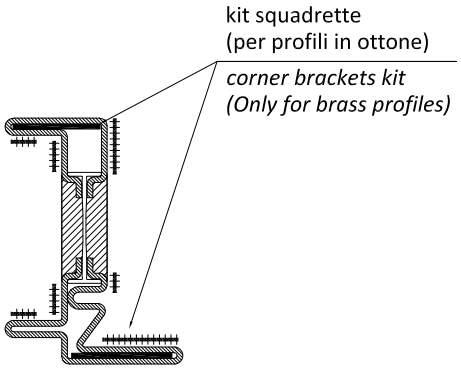


Profilo *Profile*	Kit squadrette *Corner brackets set*
Codice *Code*	Codice *Code*
PR2801-PR2801	AC 2801I
PR2803-PR2803	AC 2803I
PR2815-PR2815	AC 2803I
PR2842-PR2842	AC 2801I
PR2843-PR2843	AC 2843I
PR2801-PR2842	AC 2801I
PR2803-PR2842	AC 2801I
PR2815-PR2842	AC 2801I
PR2861-PR2861	AC 2801I
PR2862-PR2862	AC 2862I
PR2863-PR2863	AC 2803I
PR2865-PR2865	AC 2865I
PR2862-PR2863	AC 2801I

Profilo *Profile*	Kit squadrette *Corner brackets set*
Codice *Code*	Codice *Code*
PR2865-PR2863	AC 2803I
PR2871-PR2871	AC 2871I
PR2872-PR2872	AC 2872I
PR2873-PR2873	AC 2853I
PR2874-PR2874	AC 2855I
PR2875-PR2875	AC 2875I
PR2891-PR2891	AC 2891I
PR2892-PR2892	AC 2892I
PR2893-PR2893	AC 2892I
PR2895-PR2895	AC 2895I







Ottone
Utilizzare le squadrette di allineamento, sigillare tutte le superfici di contatto tra i profili che non vanno saldate.
Saldare a TIG con materiale di riporto nelle zone indicate con

Brass
Use corner brackets, seal all surfaces in touch with profiles that are not to be seam-welded.
TIG welding with filler material in the areas indicated with

Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto.

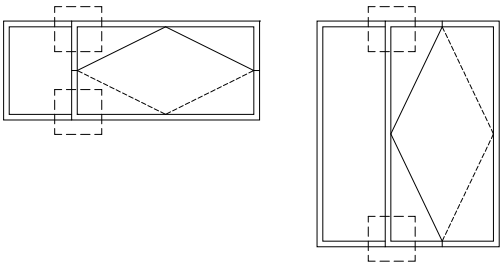
Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld all contact surfaces.

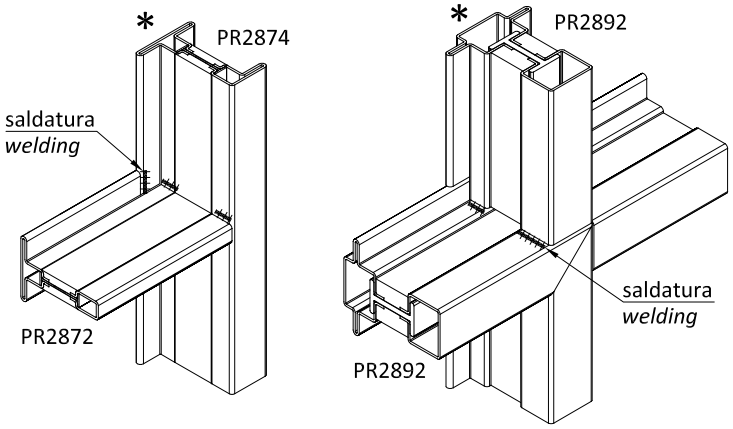
N.B. Prima di saldare l'angolo del profilo eliminare l'eventuale resina poliuretanica presente all'interno dell'aletta scaldando leggermente il profilo stesso per circa 20 mm in modo da sciogliere la resina ed eliminare le impurità presenti

ATTN. Before welding the corner please remove any trace of polyurethane resin in the internal side of casin, heating the profile for ca. 20 mm to melt the resin and removein this way all other impurities.

* Esempio "tipo" di giunzione angolare OS2 in OT67 indicativa per tutte le unioni angolari a 45°
Per scelta squadrette vedi tabella a pag. 4.4.1

* *Example of corner connection for OS2 element in brass OT67 applicable to all 45° corner connection.*
To choose the right corner bracket see table at page 4.4.1.



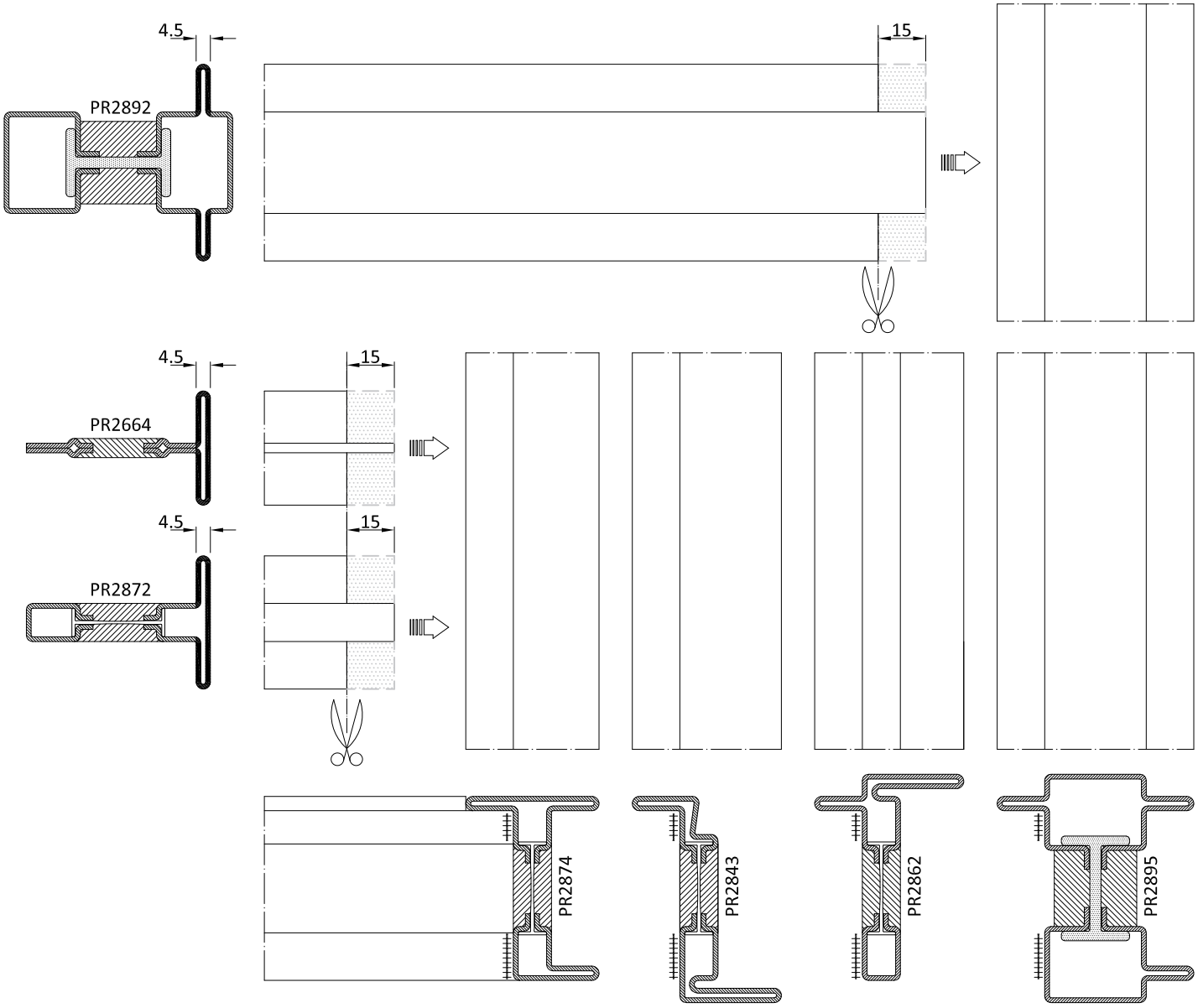


Ottone
Saldare a TIG con materiale di riporto nelle zone indicate con

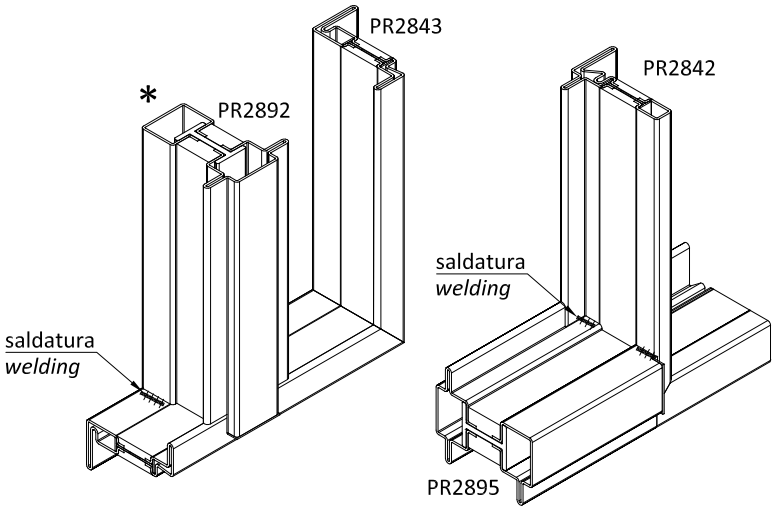
Brass
TIG welding with filler material in the areas indicated with

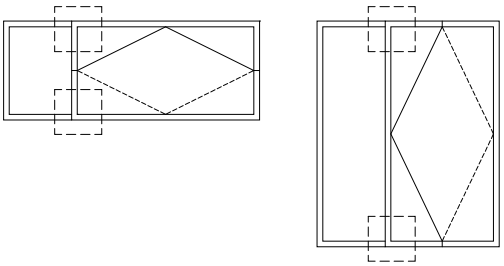
Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto.

Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld all contact surfaces.



* Esempi "tipo" di giunzione a "T"
* *Example of "T" connection for OS2*



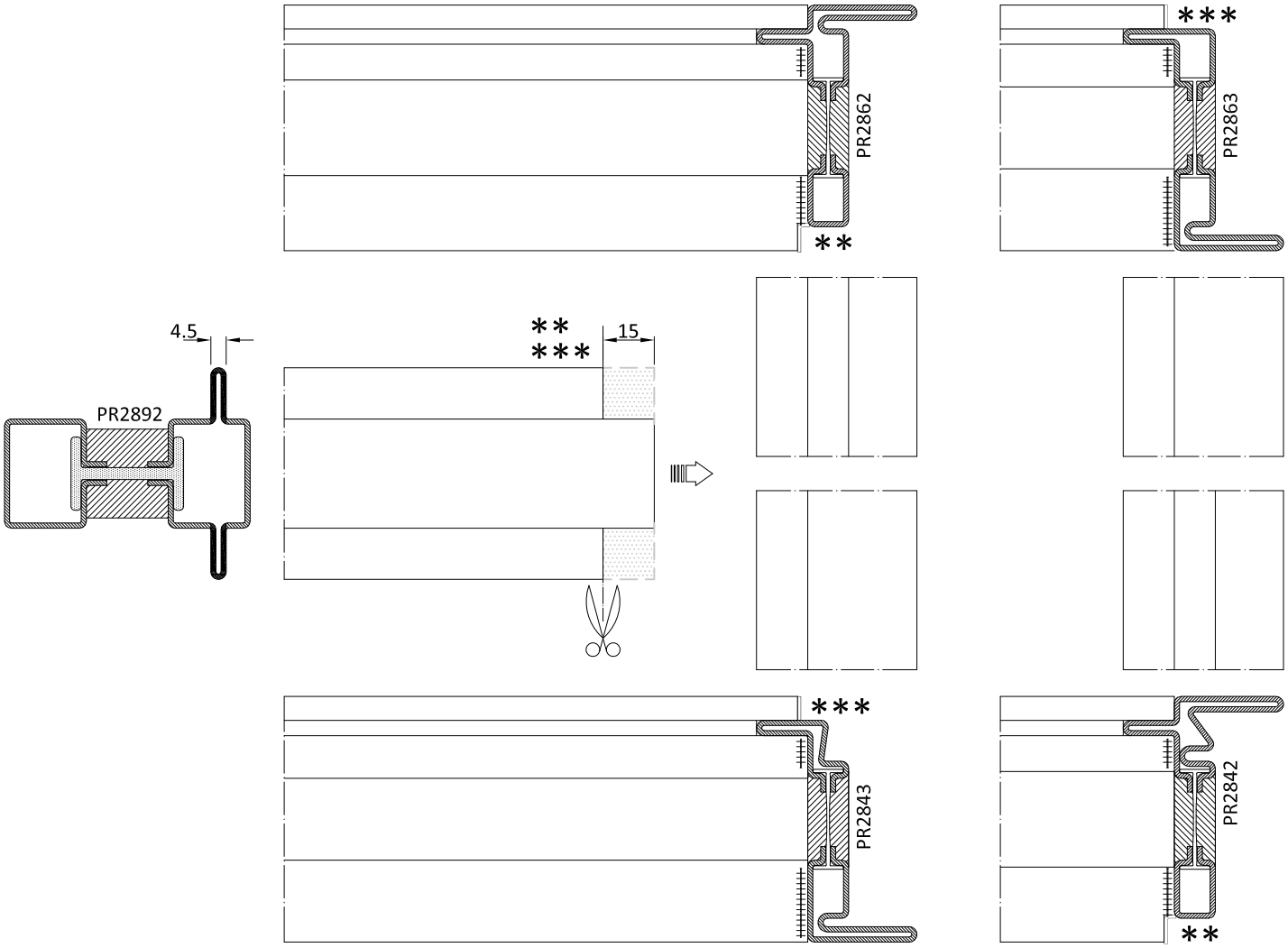


Ottone
Saldare a TIG con materiale di riporto nelle zone indicate con

Brass
TIG welding with filler material in the areas indicated with

Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto.

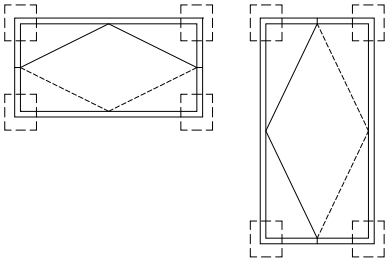
Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld all contact surfaces.



* Esempi "tipo" di giunzione a "T"
* *Example of "T" connection for OS2*

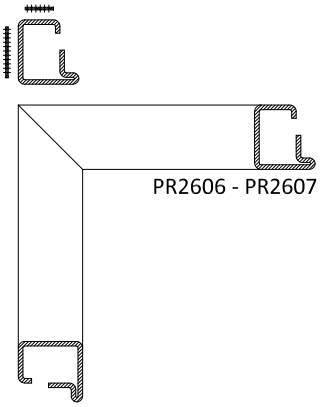
** Lavorazione pag. 4.3.2
** *Processing pg. 4.3.2*

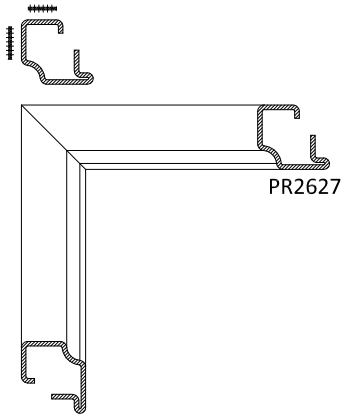
*** Lavorazione pag. 4.3.3
*** *Processing pg. 4.3.3*

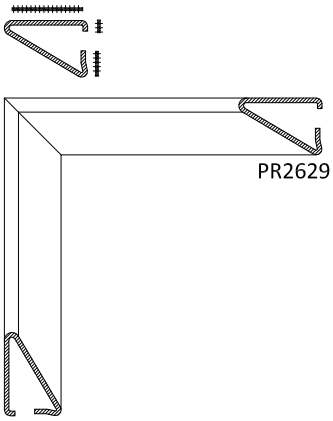


Acciaio zincato - Acciaio Corten - Acciaio inox
Saldare in continuo le superfici di contatto indicate con

Galvanised steel - Cor-ten steel - Stainless steel
Seam-weld the shown areas with

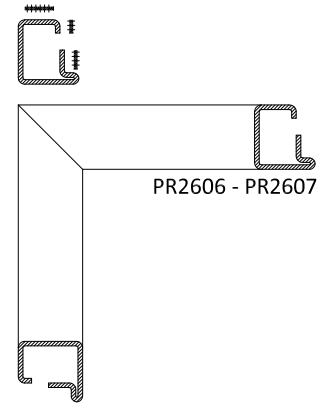


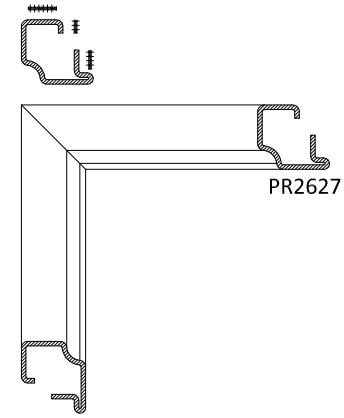


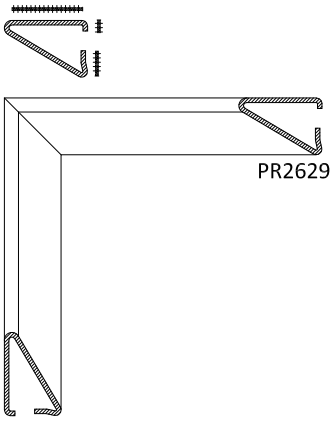


Ottone:
Saldare a TIG con materiale di riporto nelle zone indicate con

Brass:
TIG welding with filler material in the areas indicated with







A Perno di rotazione snodo bilico
B Elemento anta snodo bilico
C Elemento intermedio snodo
D Pattino lubrificante snodo
E Elemento telaio snodo fisso
F Rinforzo fissaggio snodo
G Vite A2 TSPEI M4 x 8 mm
H Spina elastica INOX Ø 3 mm
I Vite A2 TSPEI M4 x 30 mm
L Boccola inserimento vite Ø 4.2 mm
M Vite autofilettante TSP Ø 4.2 x 13 mm
N Grano M6 x 25 mm punta conica
O Cuscinetto (solo su bilico orizzontale)

A linchpin of pivot bearing
B pivot bearing on leaf
C intermediate element of pivot bearing
D lubricating runner of pivot bearing
E fixed pivot bearing on frame
F reinforcement fixing pivot bearing
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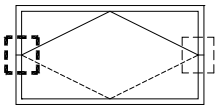
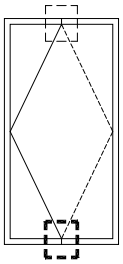
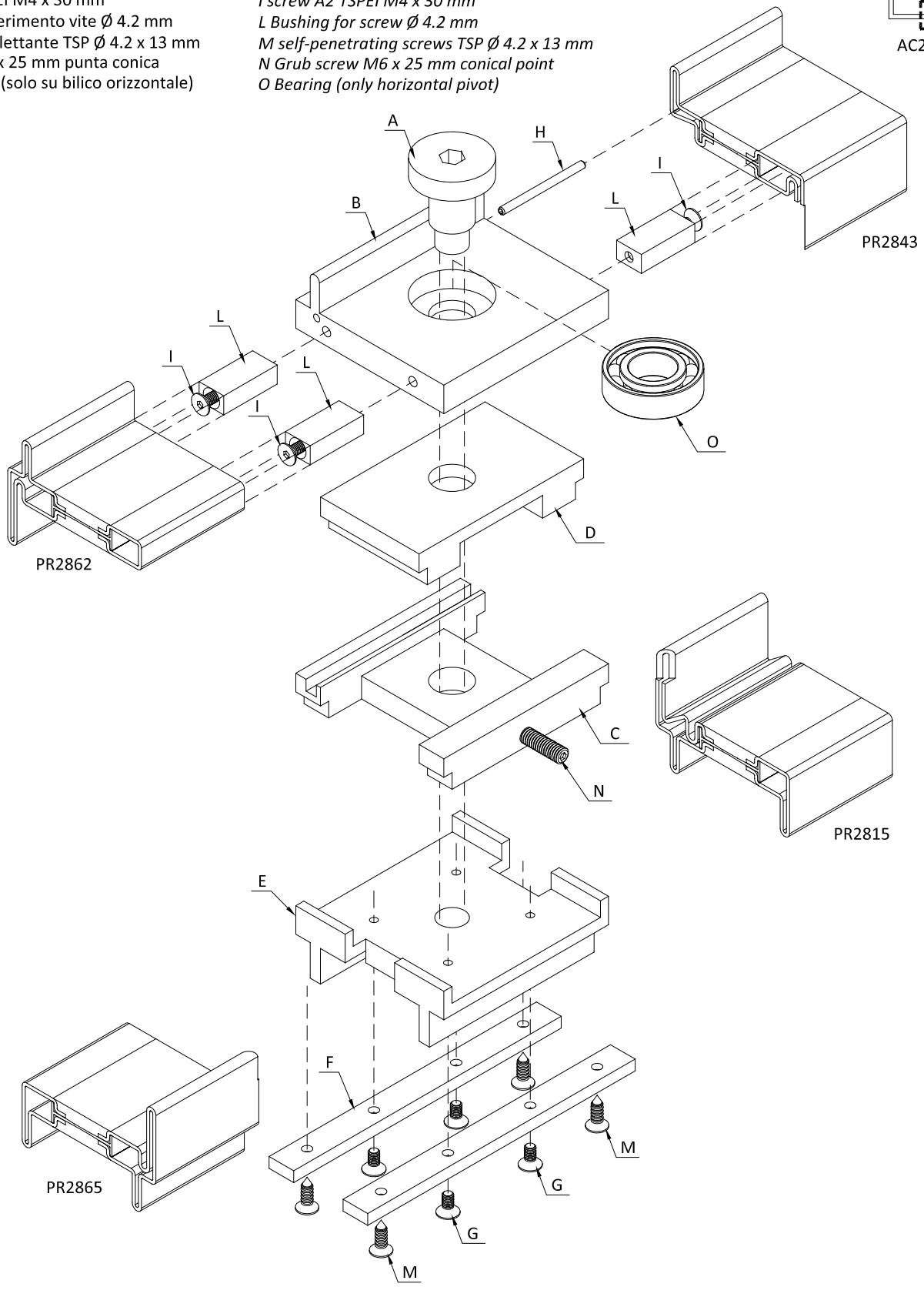
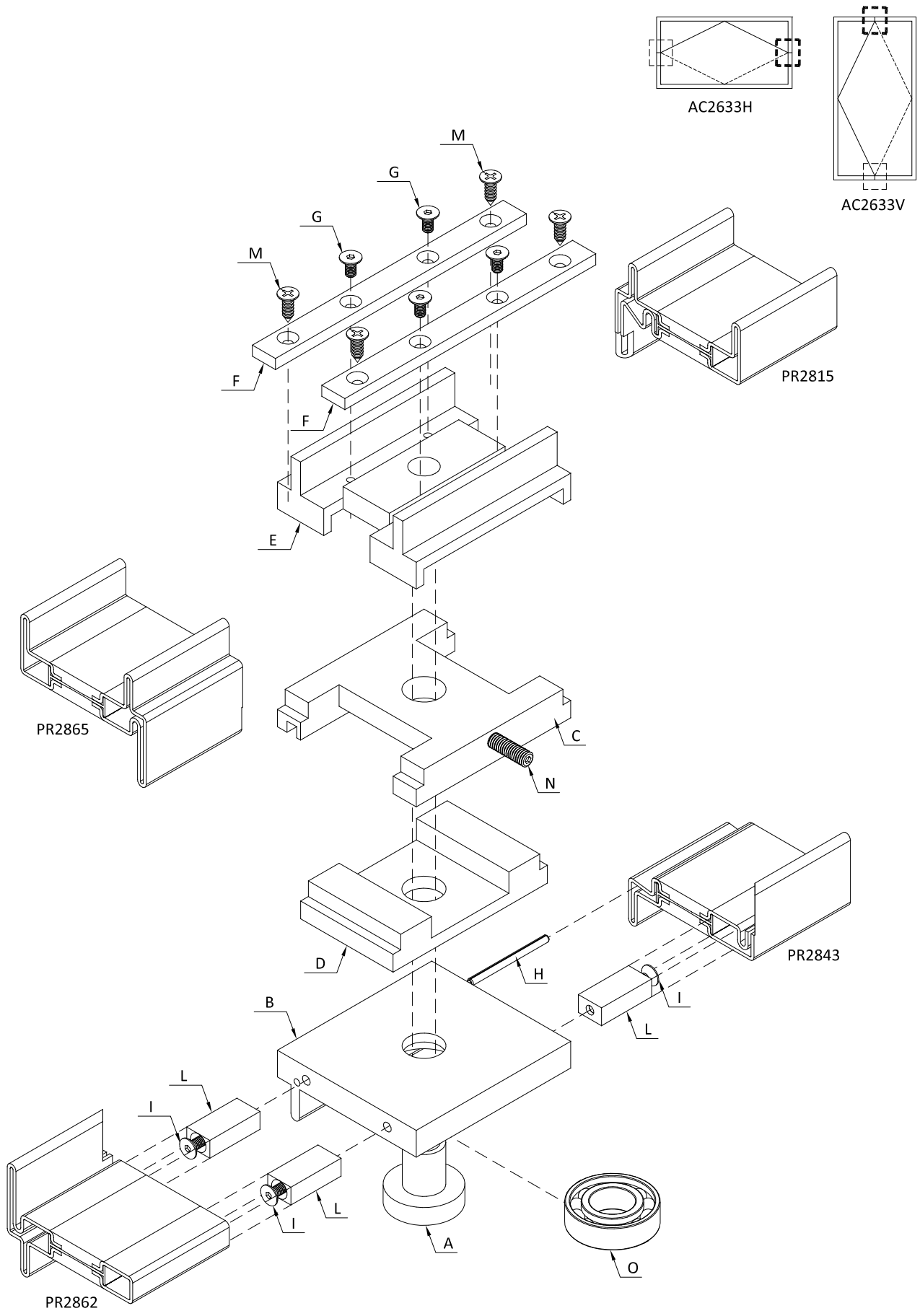
H elasthic spin in stainless steel Ø 3 mm
I screw A2 TSPEI M4 x 30 mm
L Bushing for screw Ø 4.2 mm
M self-penetrating screws TSP Ø 4.2 x 13 mm
N Grub screw M6 x 25 mm conical point
O Bearing (only horizontal pivot)


AC2633H


AC2633V




AC2633H
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PR2815
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PR2843
I
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PR2862

A Perno di rotazione snodo bilico
B Elemento anta snodo bilico
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D Pattino lubrificante snodo
E Elemento telaio snodo fisso
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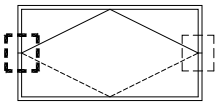
N Grub screw M6 x 25 mm conical point
O Bearing (only horizontal pivot)



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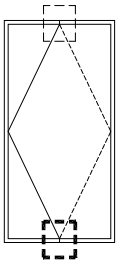

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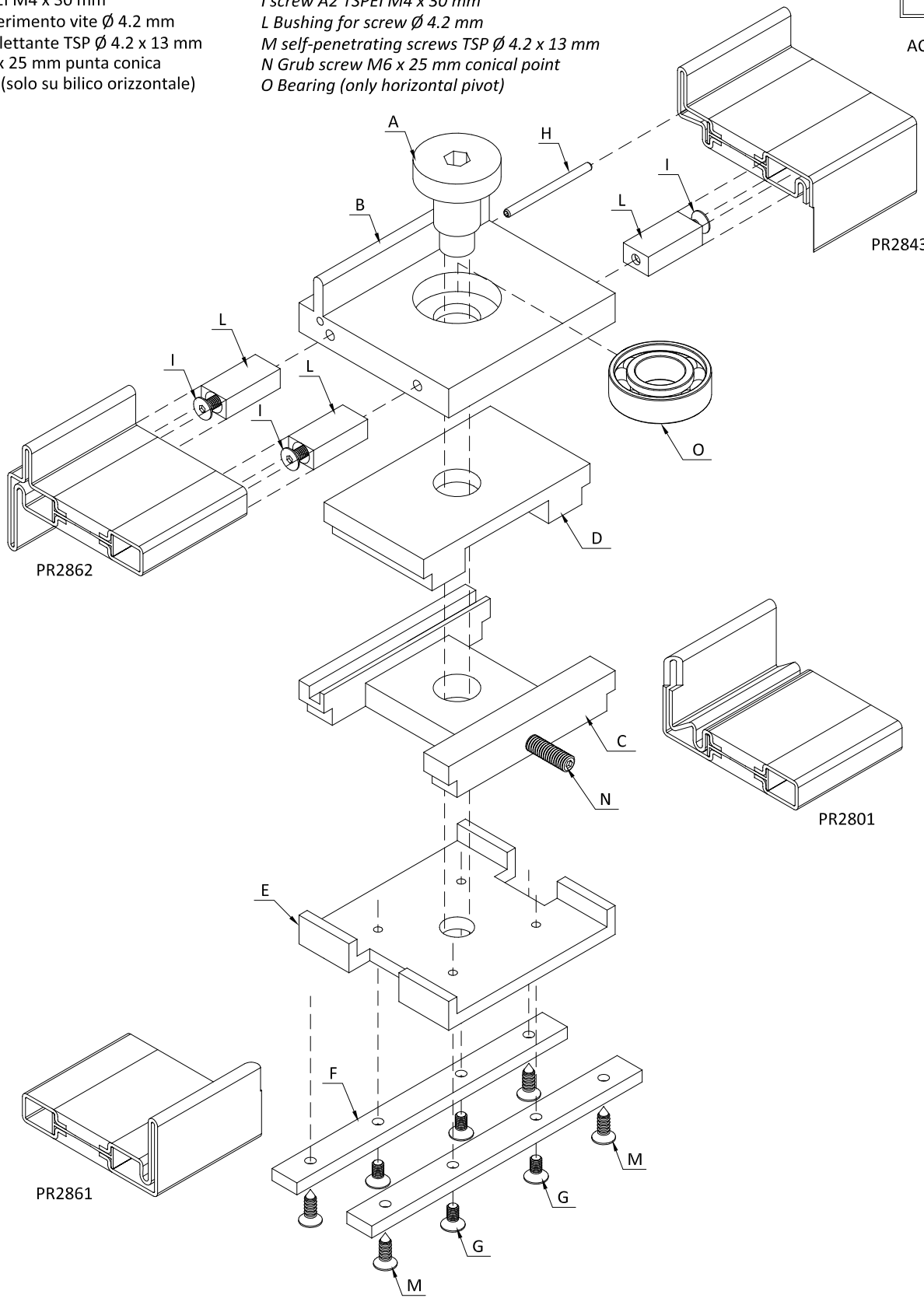

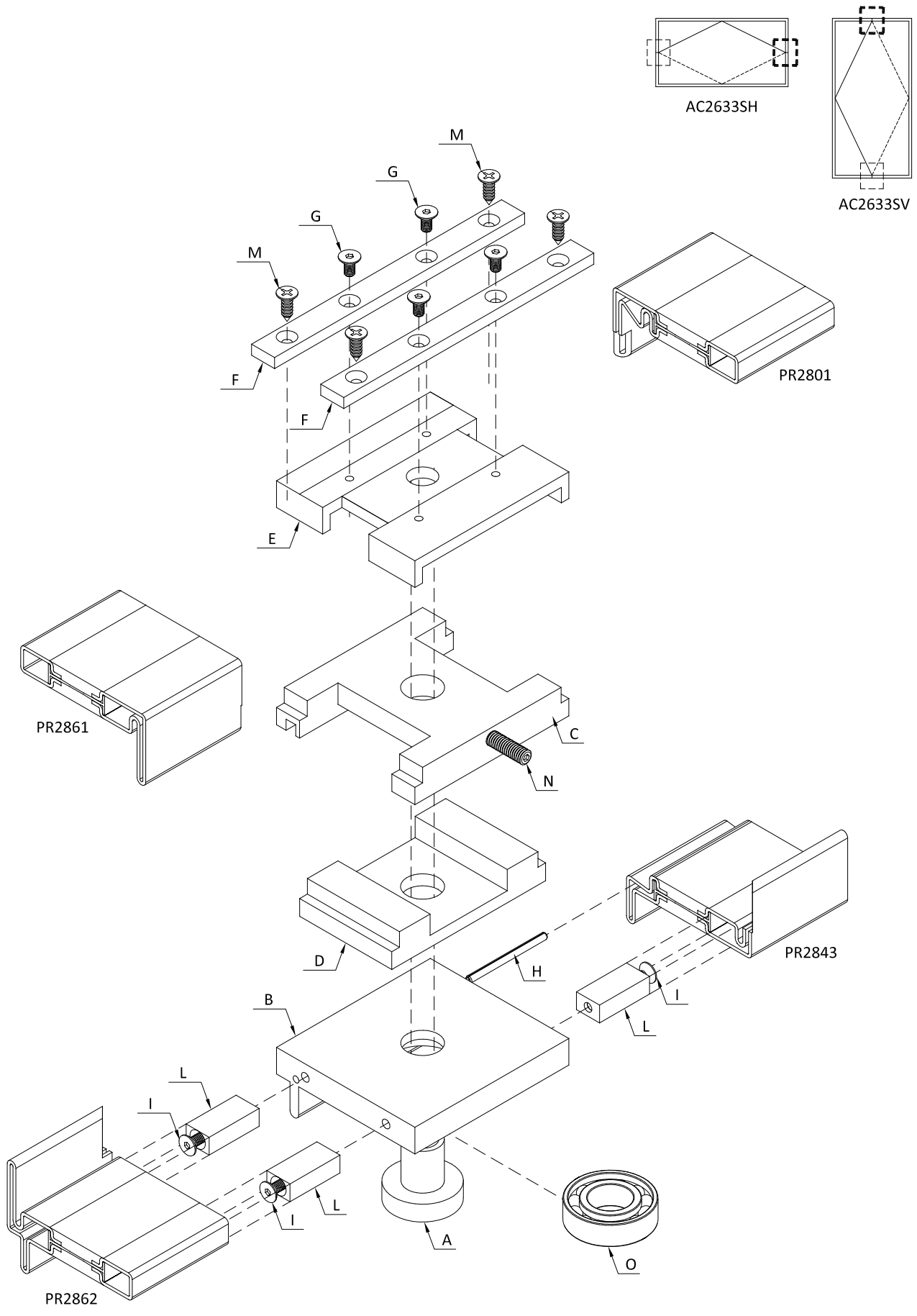
AC2633SH
AC2633SV
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PR2862

A Perno di rotazione snodo bilico
B Elemento anta snodo bilico
C Elemento intermedio snodo
D Pattino lubrificante snodo
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G Vite A2 TSPEI M4 x 8 mm
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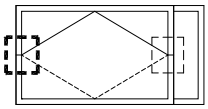
L Bushing for screw Ø 4.2 mm
M self-penetrating screws TSP Ø 4.2 x 13 mm
N Grub screw M6 x 25 mm conical point
O Bearing (only horizontal pivot)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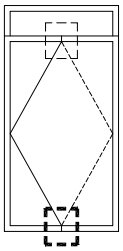
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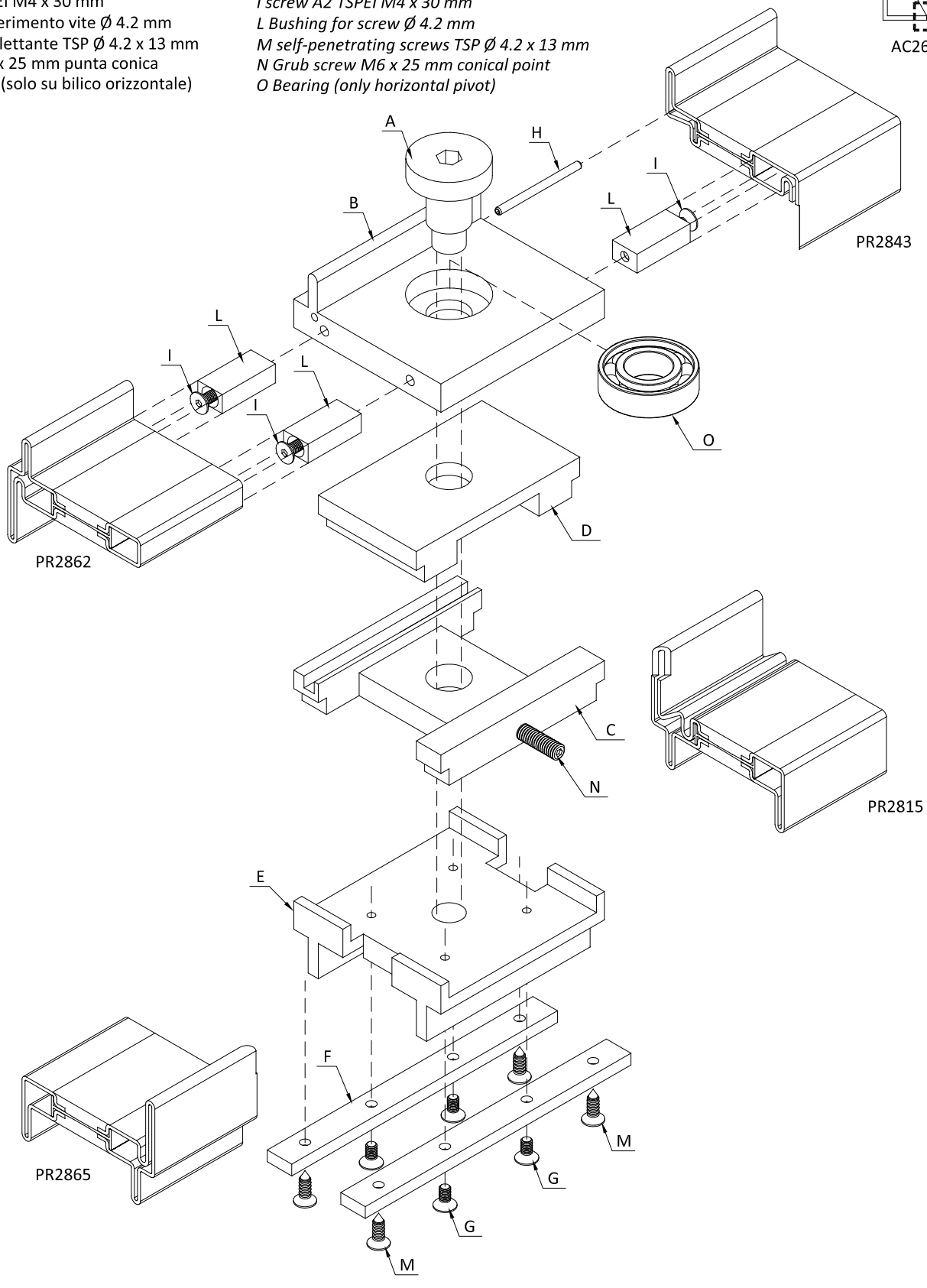

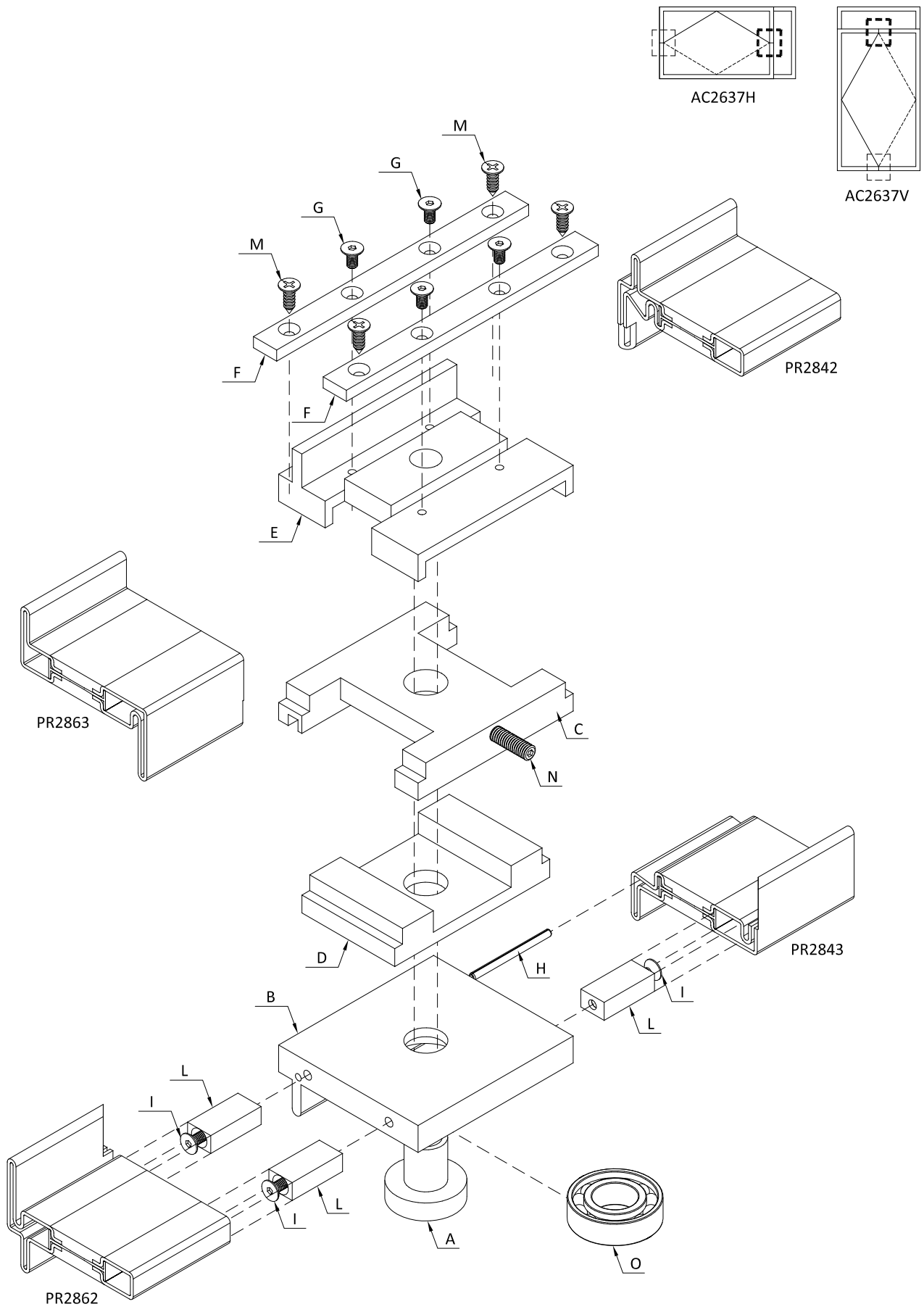
AC2637H
AC2637V
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PR2863
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PR2843
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PR2862

A Perno di rotazione snodo bilico
B Elemento anta snodo bilico
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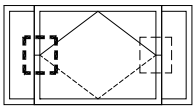
N Grub screw M6 x 25 mm conical point
O Bearing (only horizontal pivot)



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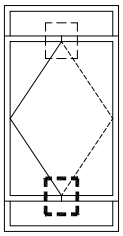

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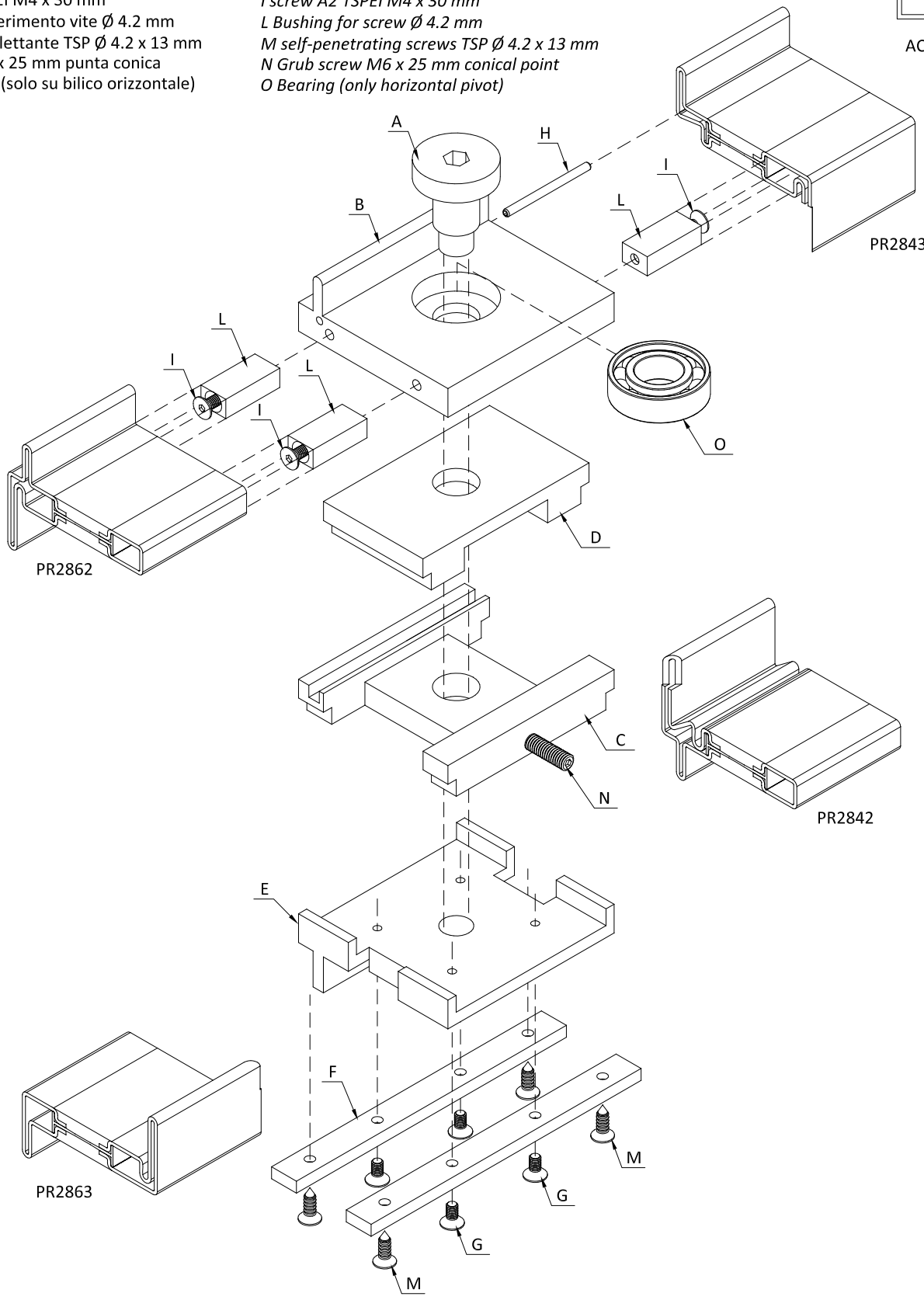

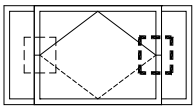

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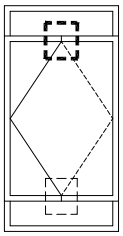

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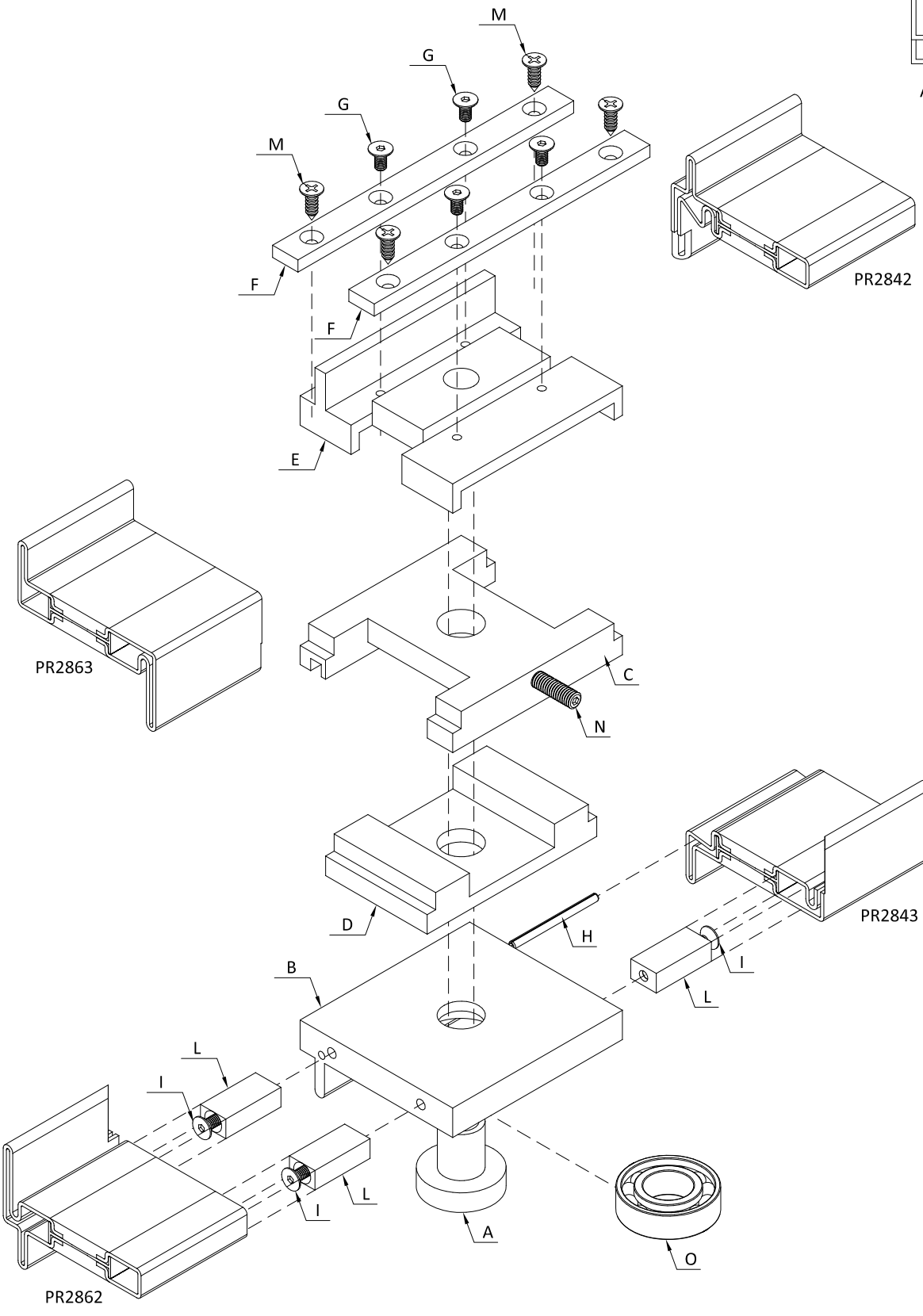
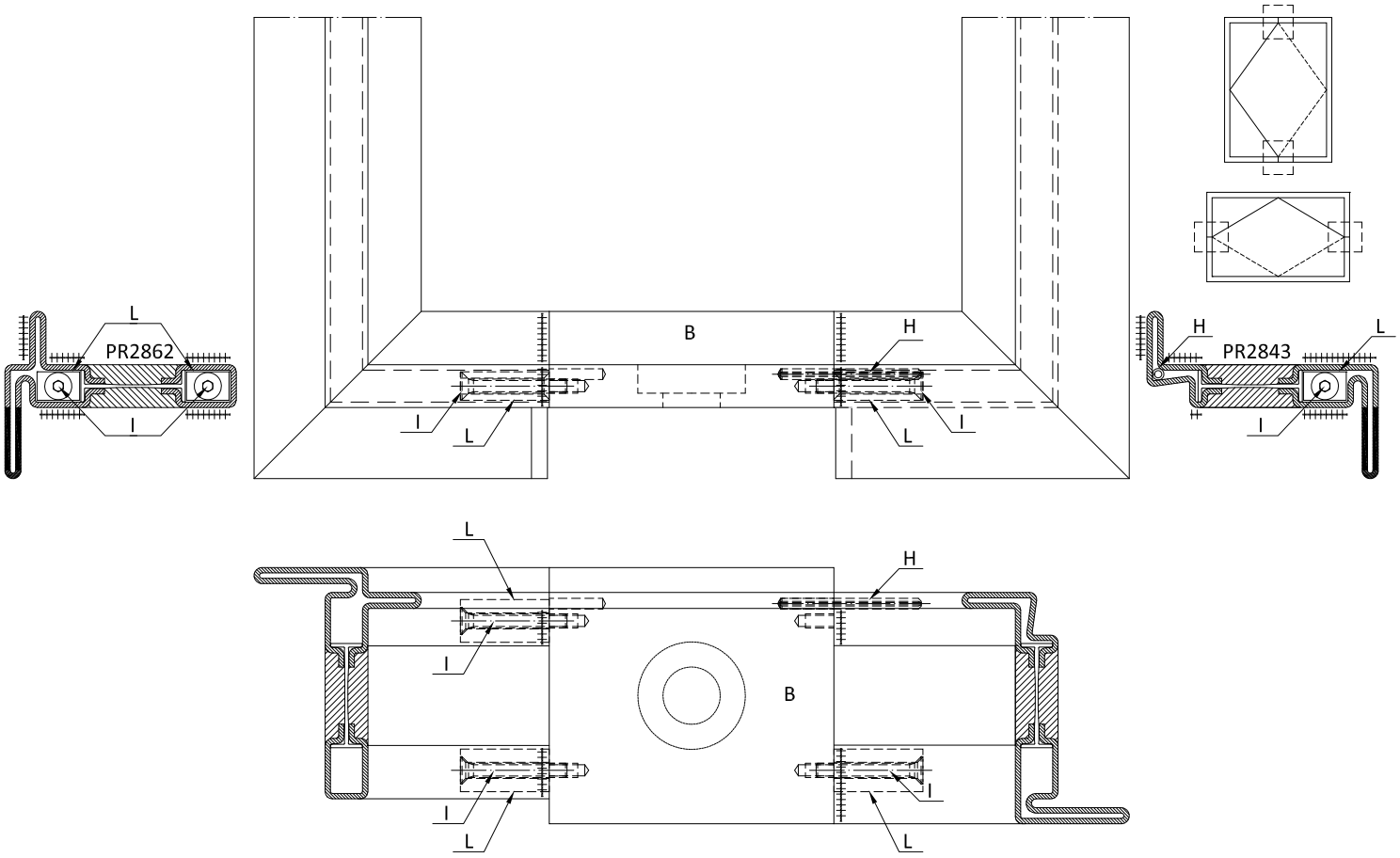


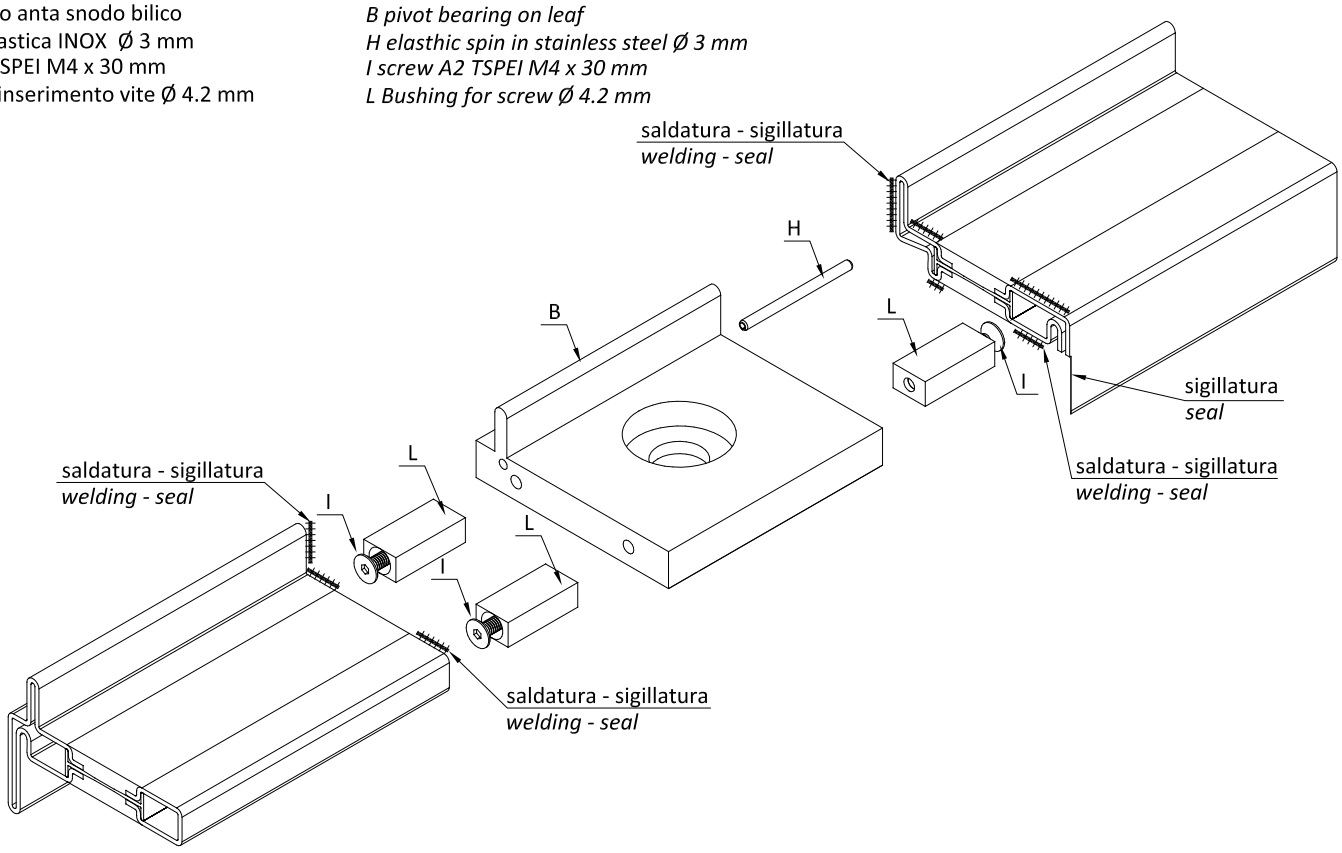


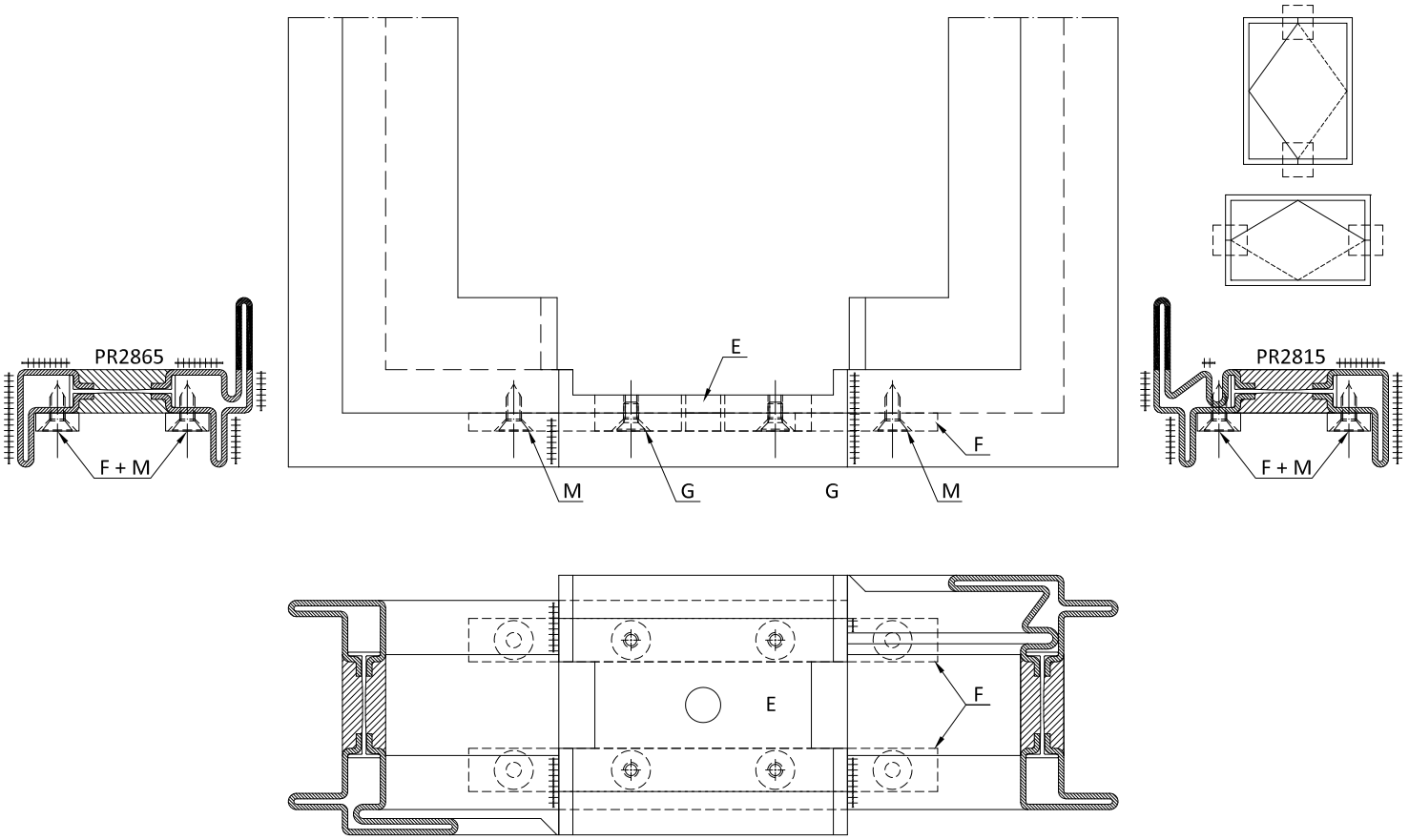
Saldare a TIG con materiale di riporto nelle zone indicate con ++++++

B Elemento anta snodo bilico
H Spina elastica INOX Ø 3 mm
I Vite A2 TSPEI M4 x 30 mm
L Boccola inserimento vite Ø 4.2 mm

TIG welding with filler material in the areas indicated with ++++++

B pivot bearing on leaf
H elasthic spin in stainless steel Ø 3 mm
I screw A2 TSPEI M4 x 30 mm
L Bushing for screw Ø 4.2 mm



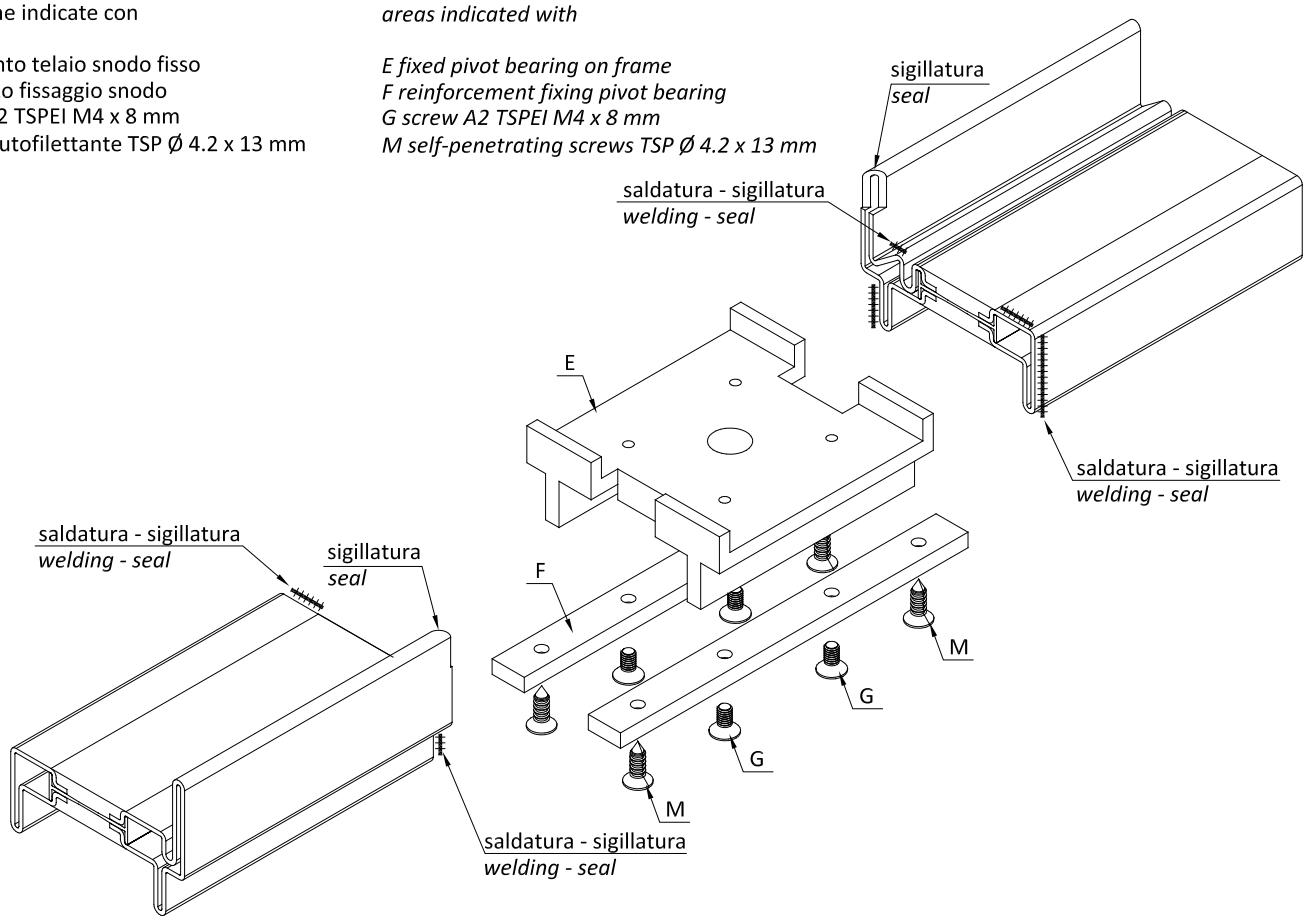


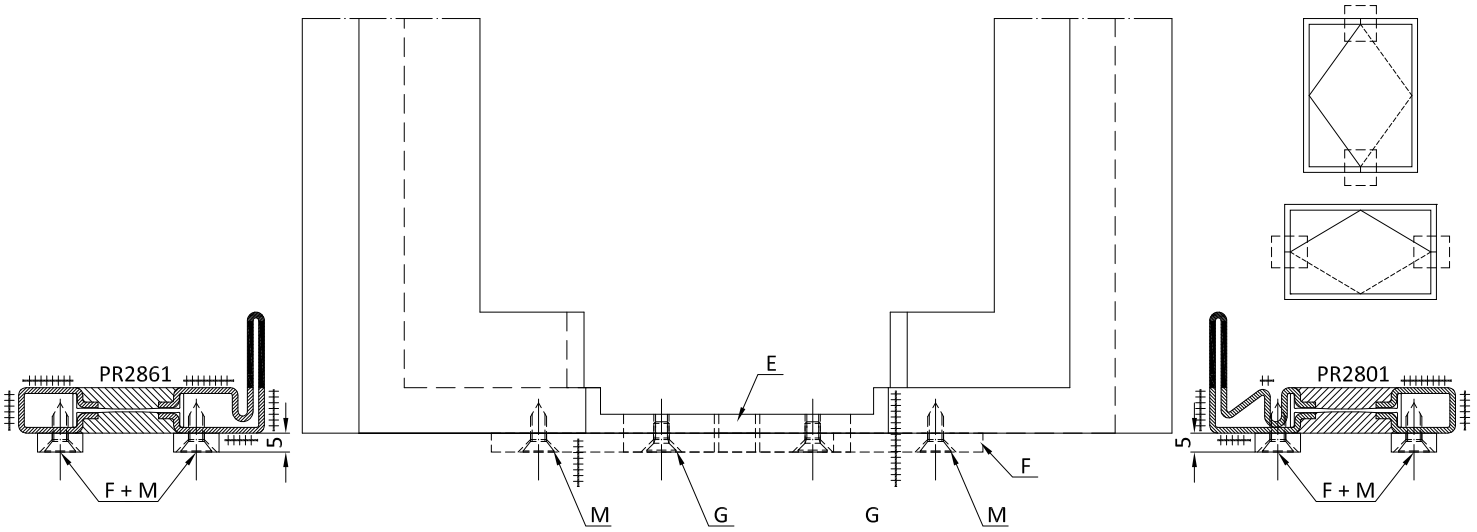
Saldare a TIG con materiale di riporto nelle zone indicate con

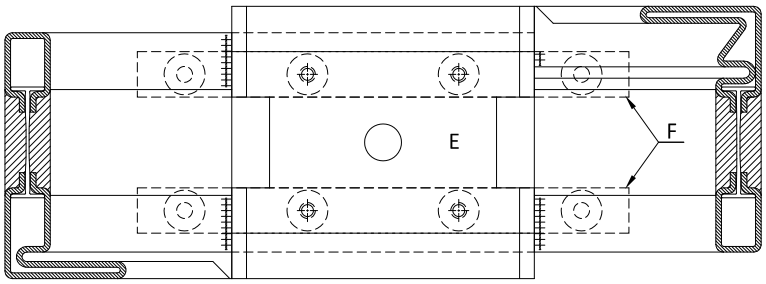
E Elemento telaio snodo fisso
F Rinforzo fissaggio snodo
G Vite A2 TSPEI M4 x 8 mm
M Vite autofilettante TSP Ø 4.2 x 13 mm

TIG welding with filler material in the areas indicated with

E fixed pivot bearing on frame
F reinforcement fixing pivot bearing
G screw A2 TSPEI M4 x 8 mm
M self-penetrating screws TSP Ø 4.2 x 13 mm







Saldare a TIG con materiale di riporto nelle zone indicate con

E Elemento telaio snodo fisso
F Rinforzo fissaggio snodo
G Vite A2 TSPEI M4 x 8 mm
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TIG welding with filler material in the areas indicated with

E fixed pivot bearing on frame
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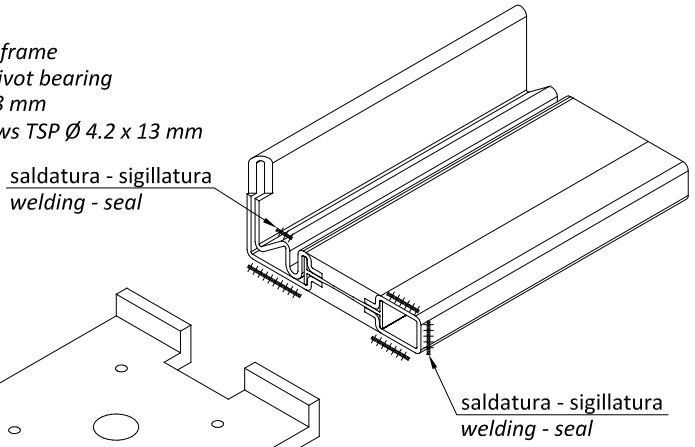
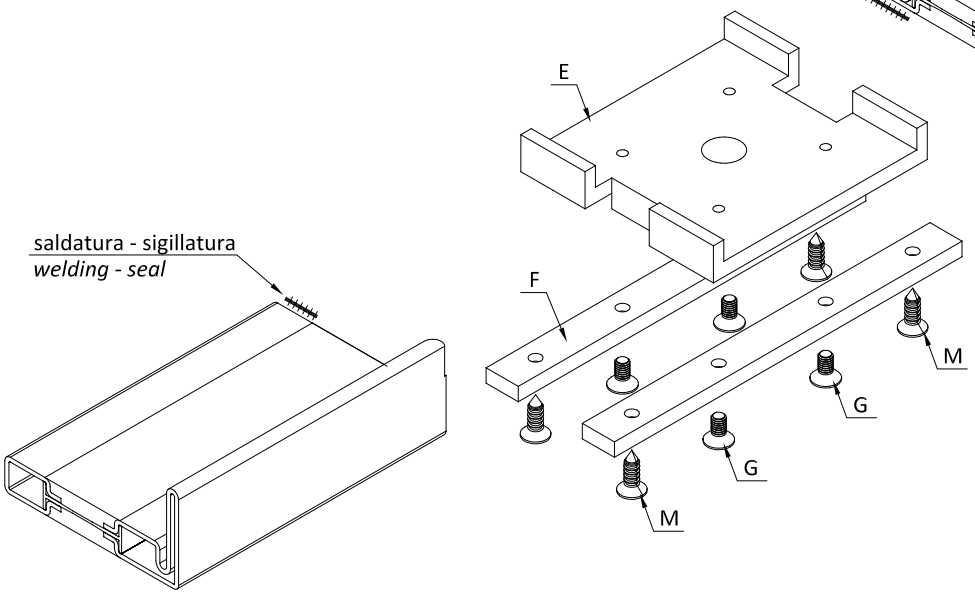
G screw A2 TSPEI M4 x 8 mm
M self-penetrating screws TSP Ø 4.2 x 13 mm





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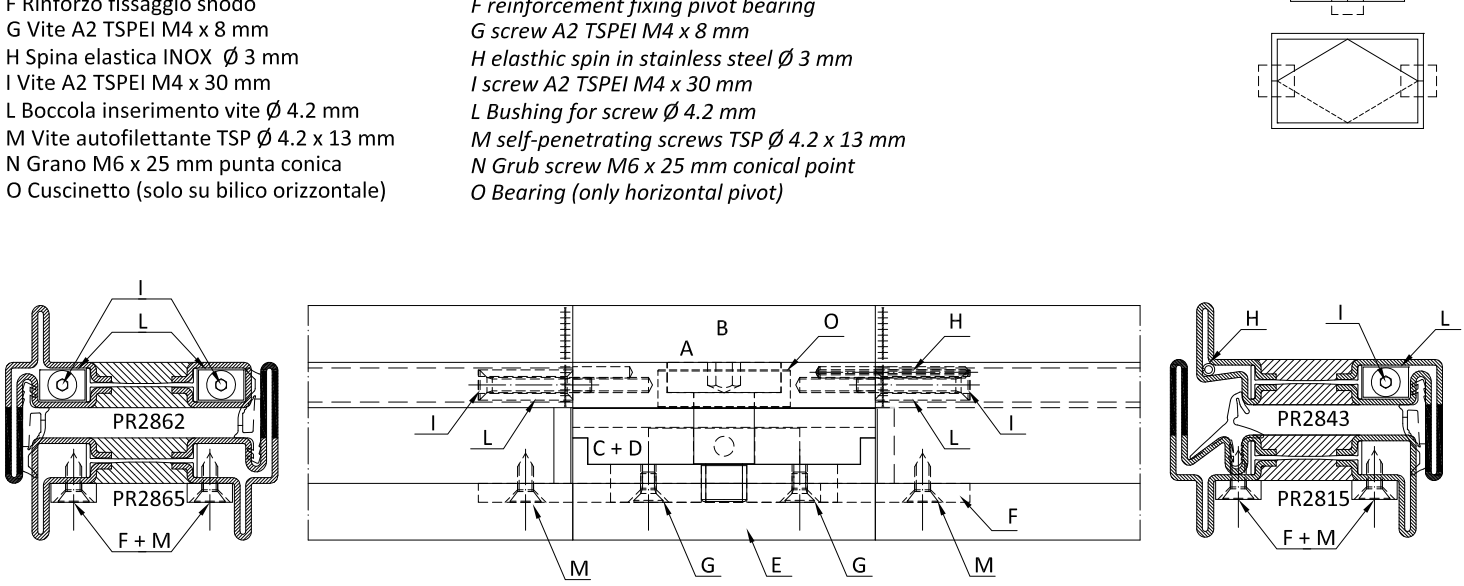
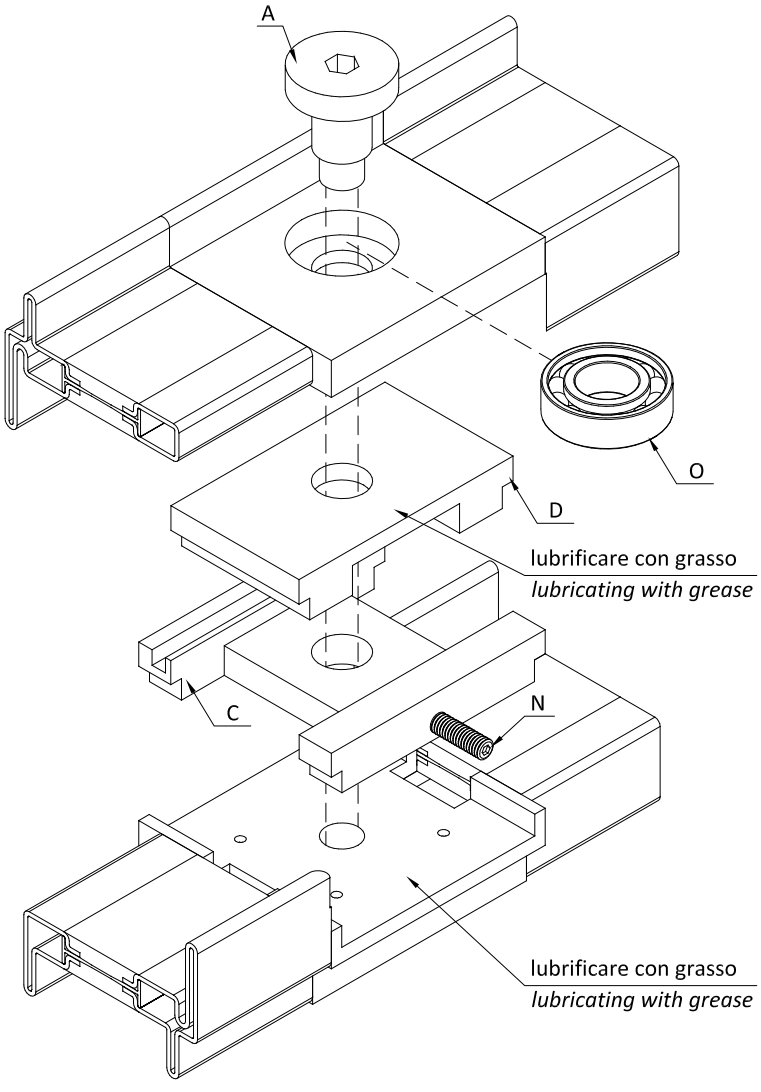
O Bearing (only horizontal pivot)





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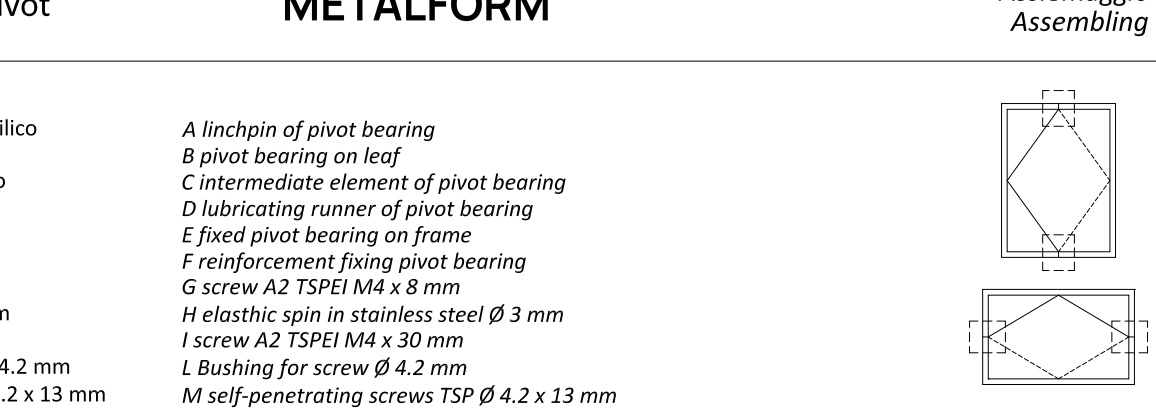
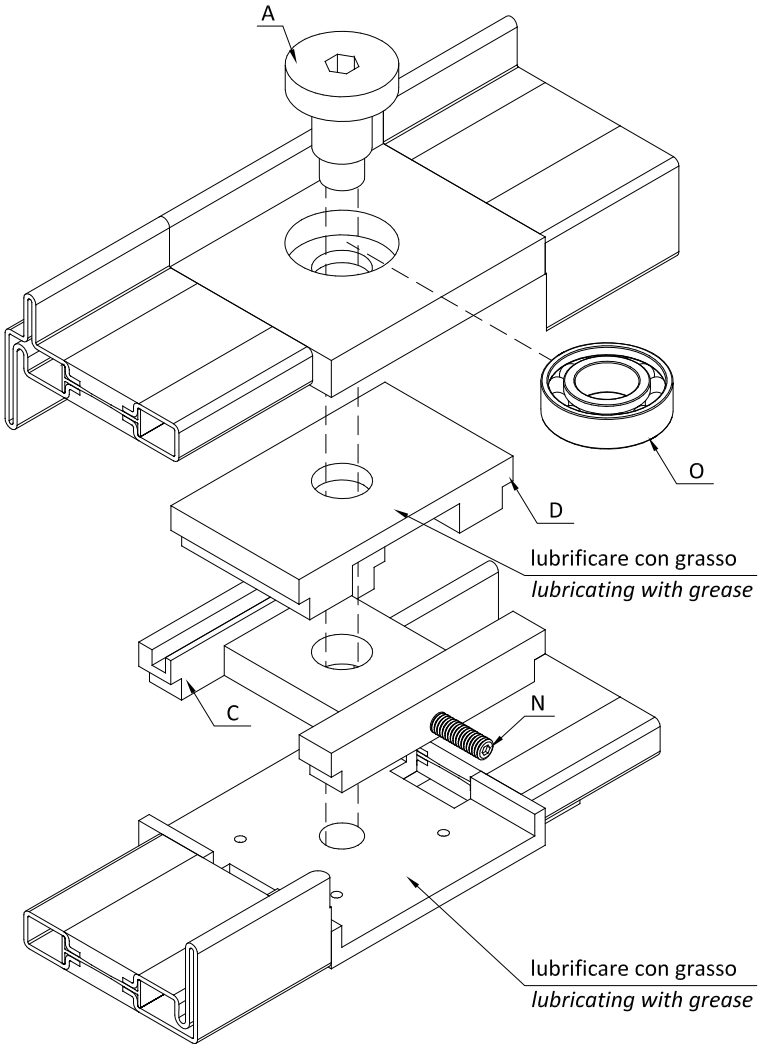
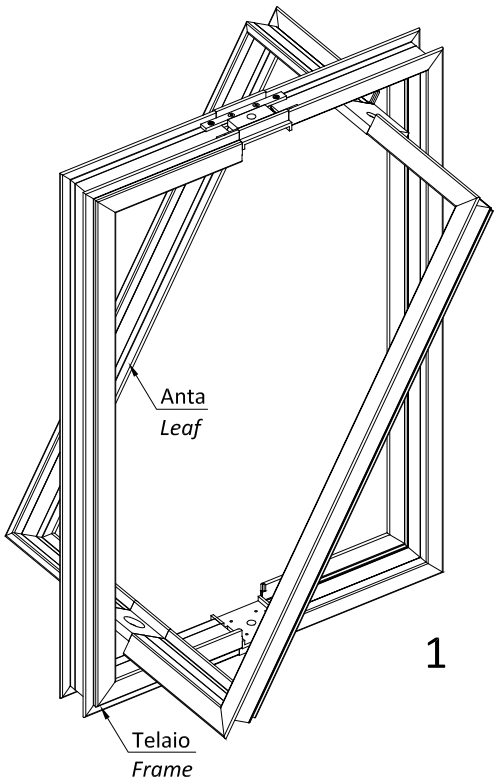
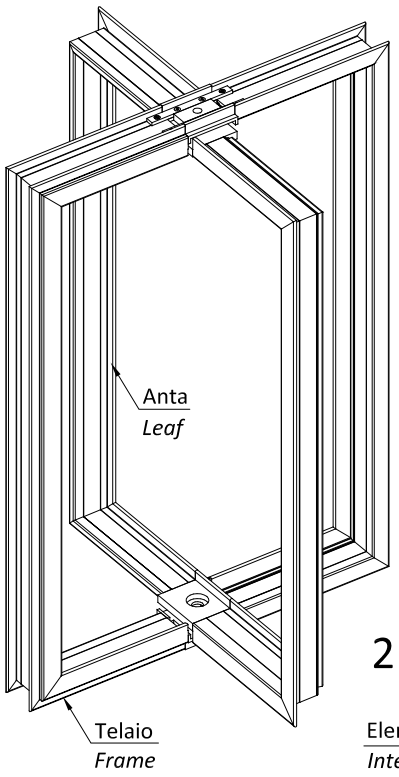
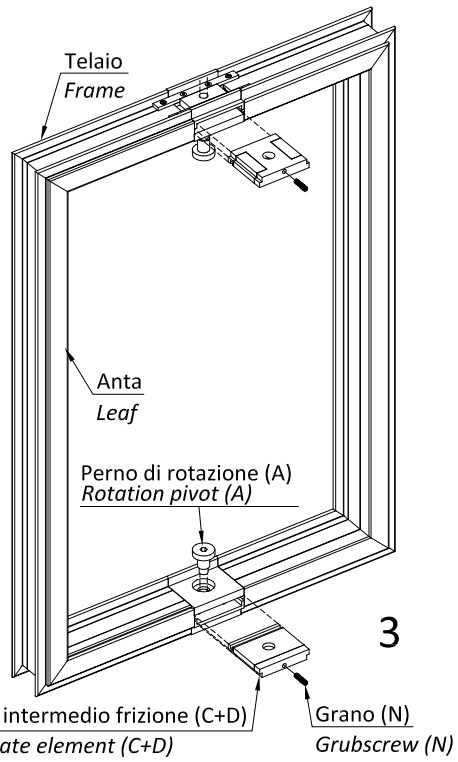
O Bearing (only horizontal pivot)

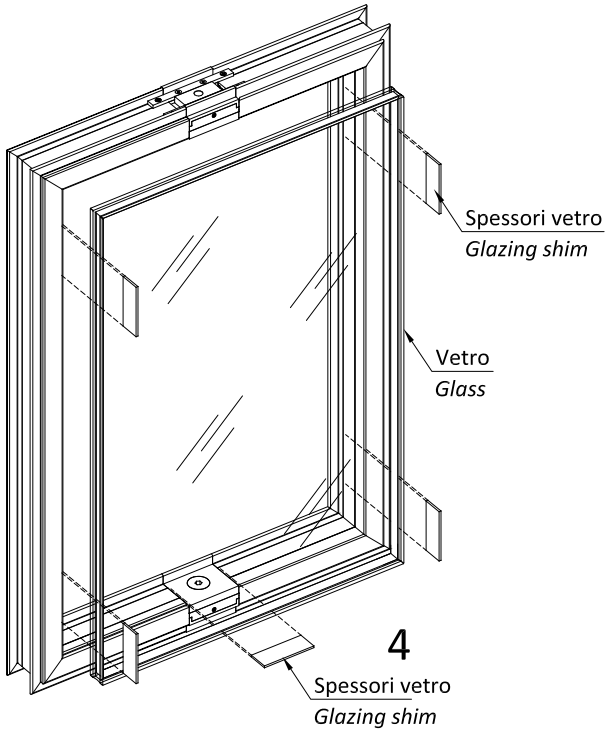


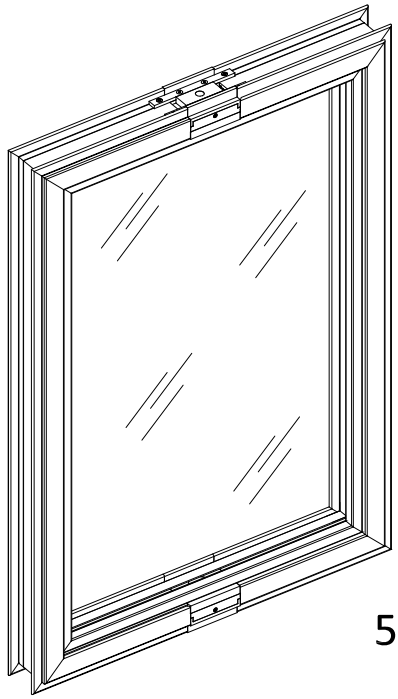












1 Inserire l'anta inclinata all'interno del telaio.

2 allineare verticalmente l'anta rispetto all'asse dello snodo bilico.

3 chiudere l'anta; inserire l'elemento intermedio (C+D lubrificando con grasso) della frizione e il perno (A) fissandolo con il grano (N) in dotazione.

4 Inserire il vetro avendo cura del corretto posizionamento degli spessori.

5 inserire il fermavetro.

1 Insert the leaf (inclined) in the frame

2 align vertically the leaf with the pivot bearing's axis

3 close the leaf; insert the intermediate element (C+D lubricating with grease) of pivot bearing and the linchpin (A) fixing it with the grub screw (N)

4 install the glass looking at the correct position of glass shims

5 install the glazing bead

1) Eseguire i fori come da disegno (lavorazione effettuabile con maschera AT2618).

2) Posizionare lo scarico acqua e sigillare fissare con viti in dotazione Inox A2.

3) Posizionare la guarnizione di giunto centrale e gli angoli vulcanizzati, incollare gli angoli alla guarnizione a mezzo di colla ciano-acrilica.

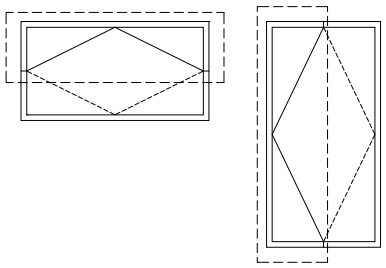
4) Sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.

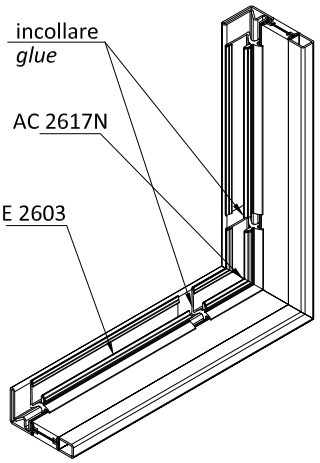
1) Drill the holes as shown in the diagram (using jig AT2618).

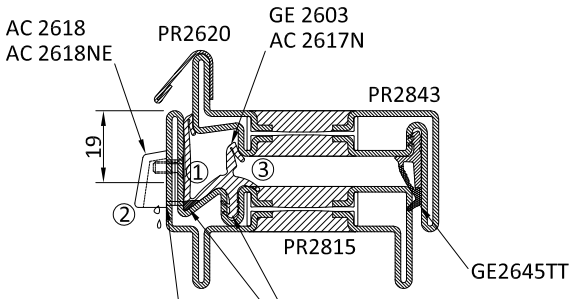
2) Position the water drain, seal and secure with the supplied A2 stainless screw.

3) Position the central weather strip and vulcanised corner, glue the corners to the weathers strip using cyanoacrylate glue.

4) Seal the entire lower base of the frame and vertically for 150 mm

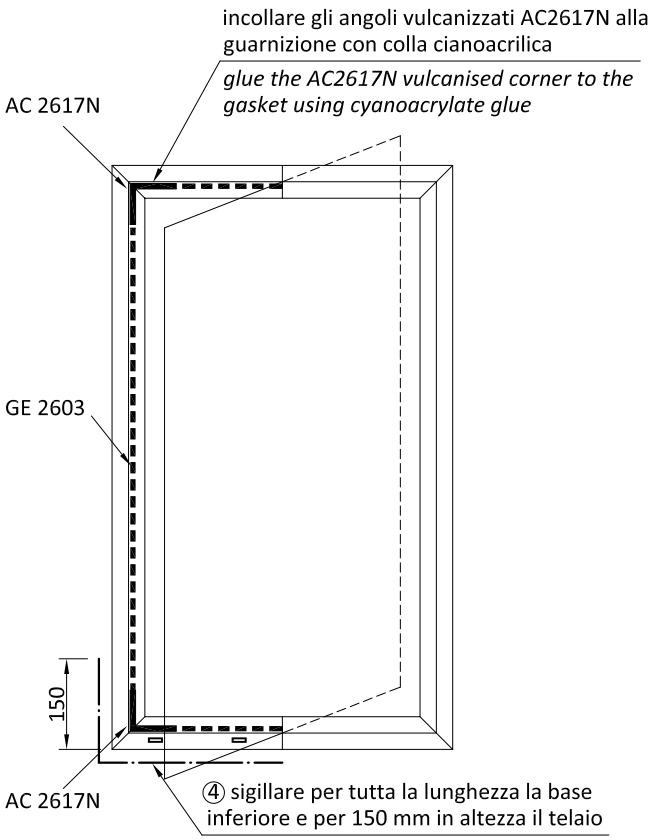


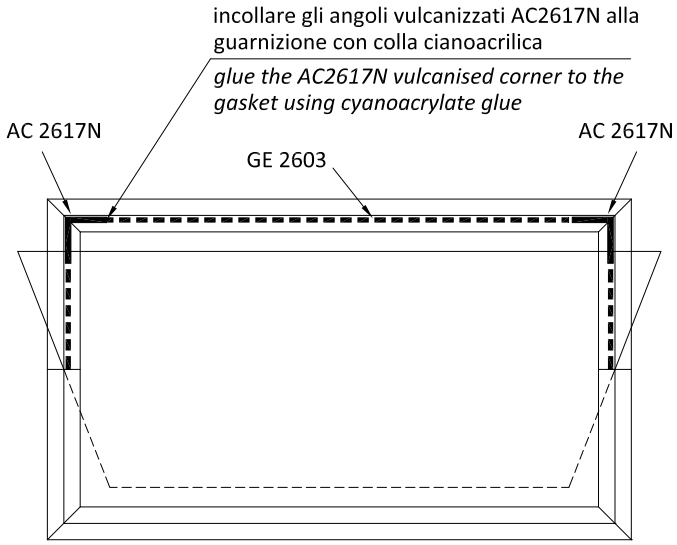


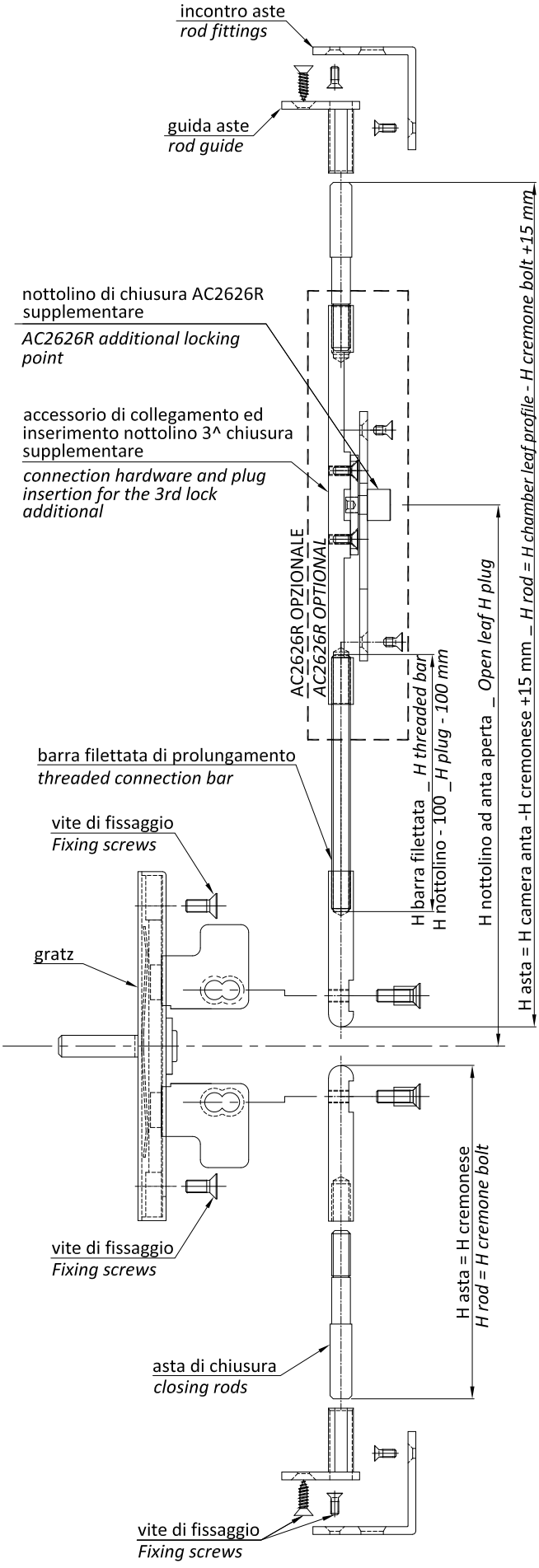


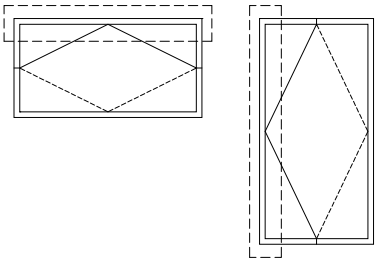
sigillare per tutta la lunghezza la base inferiore e per 150 mm in altezza il telaio.
seal the entire base of the frame and vertically for 150 mm

sigillare il perimetro dello scarico acqua
seal the perimeter of the water drip









1) Avvitare le aste di chiusura agli accessori di collegamento

2) Inserire le aste negli spacchi predisposti agli angoli dell'anta

3) Inserire e fissare il GRATZ all'anta

4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione

5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

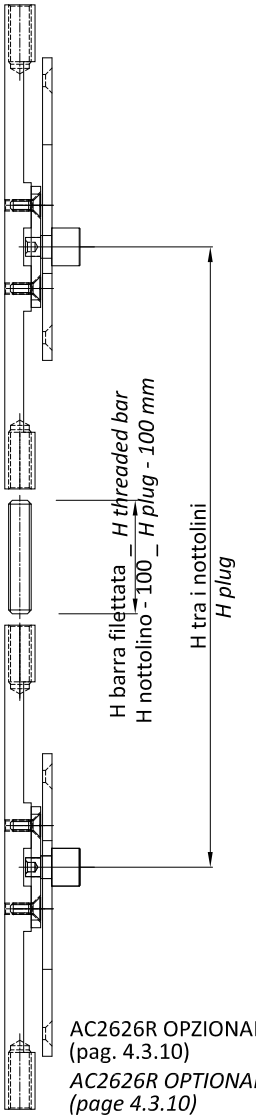
2) Insert the rods into the slits on the leaf corners

3) Insert the "GRATZ" mechanism into the leaf and secure

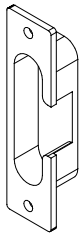
4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws

5) Insert the rod guides into the slits and fix them to the leaf

6) Secure the fittings to the frame



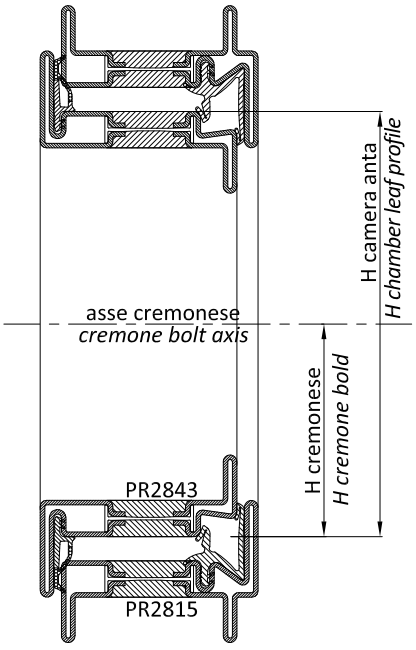
AC2626R OPZIONALE
(pag. 4.3.10)
AC2626R OPTIONAL (page 4.3.10)

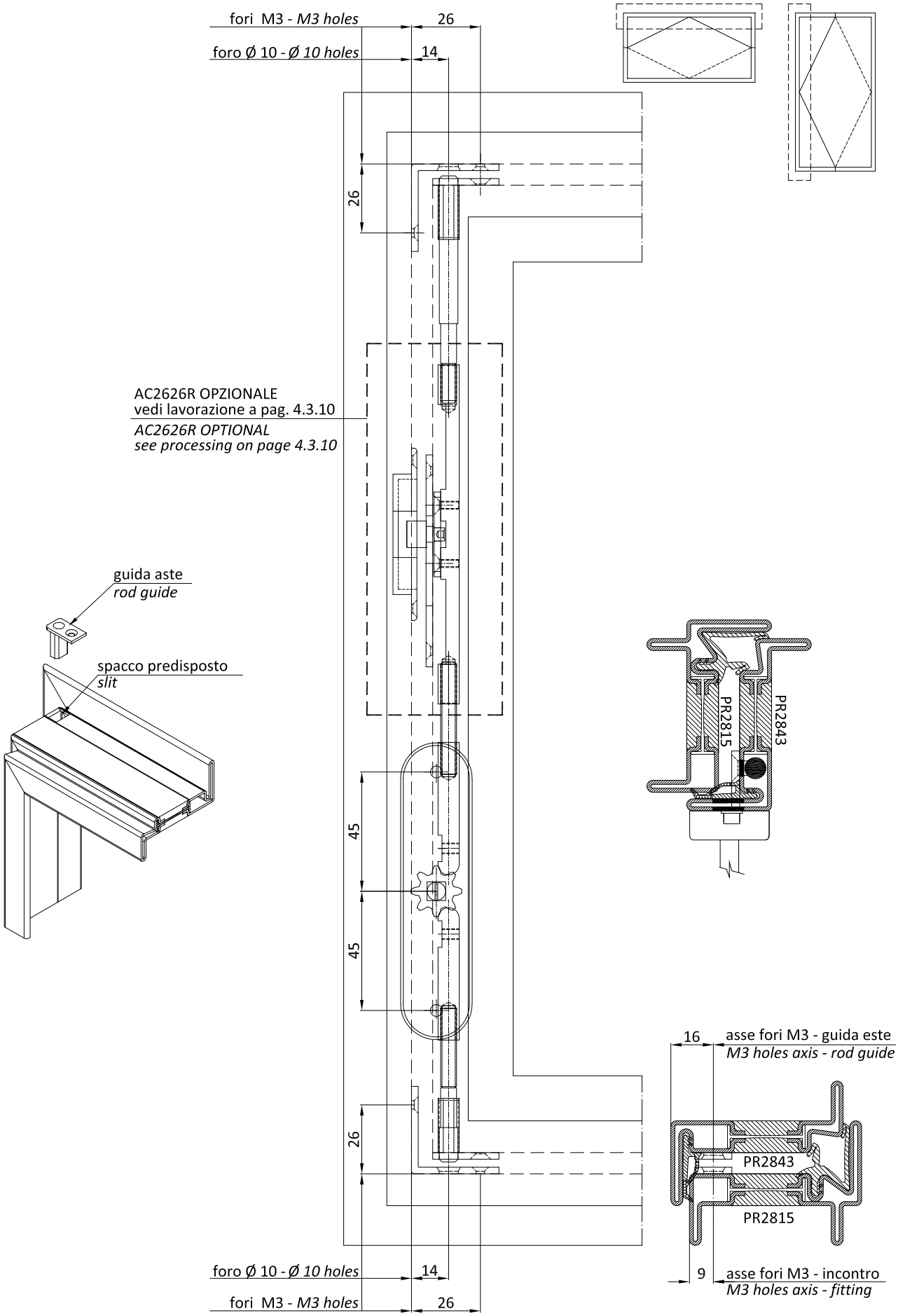


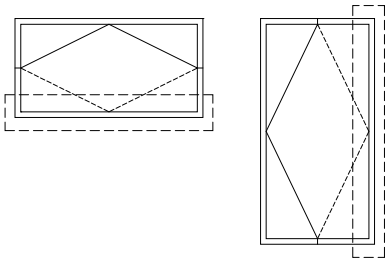
AC2626R incontro 3^ chiusura OPZIONALE
AC2626R 3rd lock strike plate OPTIONAL

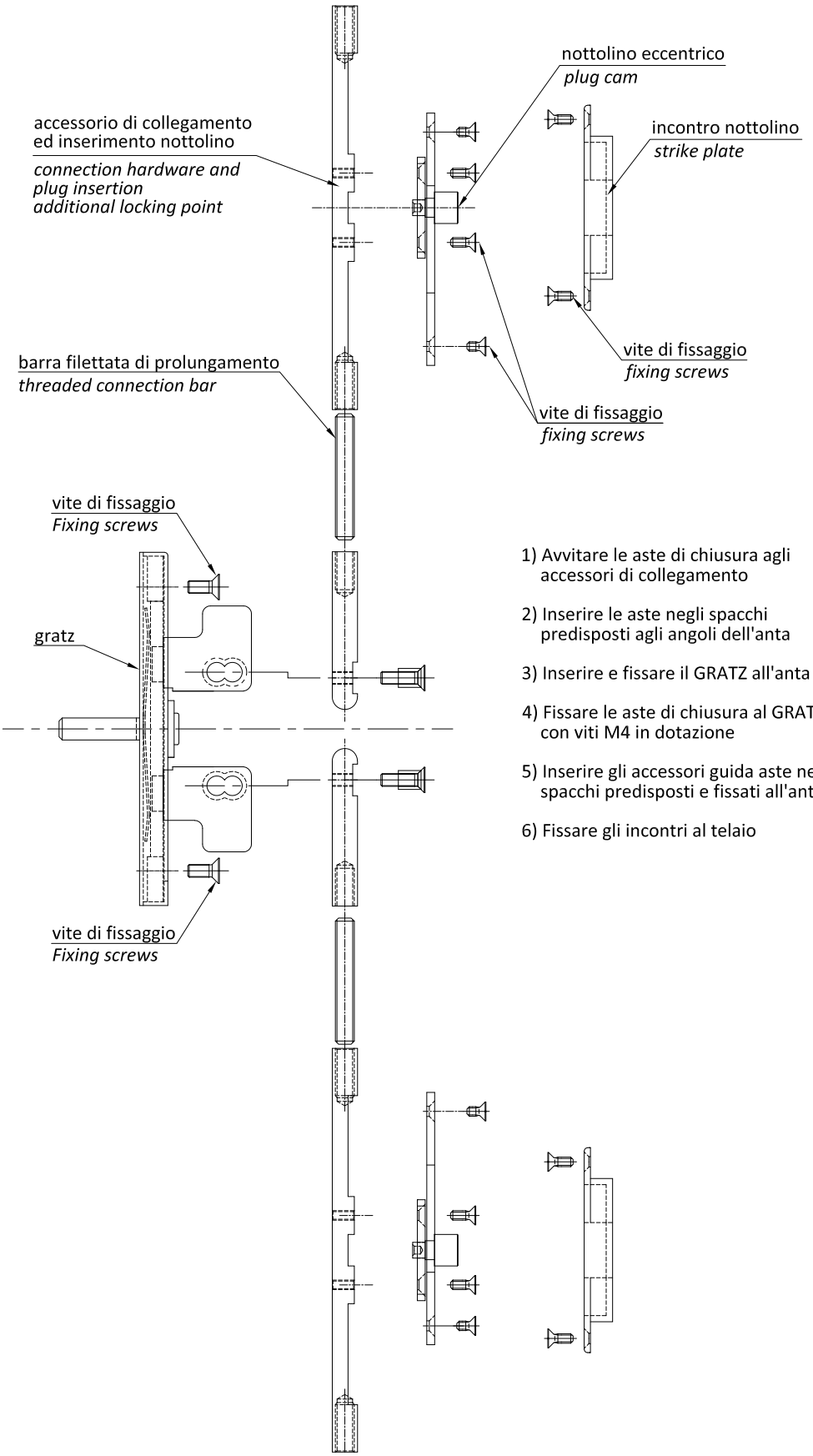
N.B. prevedere un punto di chiusura ogni 1000 mm max

Attn. Consider one locking point every 1000 mm max




fori M3 - M3 holes
26
foro Ø 10 - Ø 10 holes
14
26
AC2626R OPZIONALE
vedi lavorazione a pag. 4.3.10
AC2626R OPTIONAL
see processing on page 4.3.10
guida aste
rod guide
spacco predisposto
slit
PR2815
PR2843
45
45
26
16
asse fori M3 - guida este
M3 holes axis - rod guide
PR2843
PR2815
9
asse fori M3 - incontro
M3 holes axis - fitting
foro Ø 10 - Ø 10 holes
14
fori M3 - M3 holes
26





1) Avvitare le aste di chiusura agli accessori di collegamento

2) Inserire le aste negli spacchi predisposti agli angoli dell'anta

3) Inserire e fissare il GRATZ all'anta

4) Fissare le aste di chiusura al GRATZ con viti M4 in dotazione

5) Inserire gli accessori guida aste negli spacchi predisposti e fissati all'anta

6) Fissare gli incontri al telaio

1) Screw the closing rods to the connection fittings

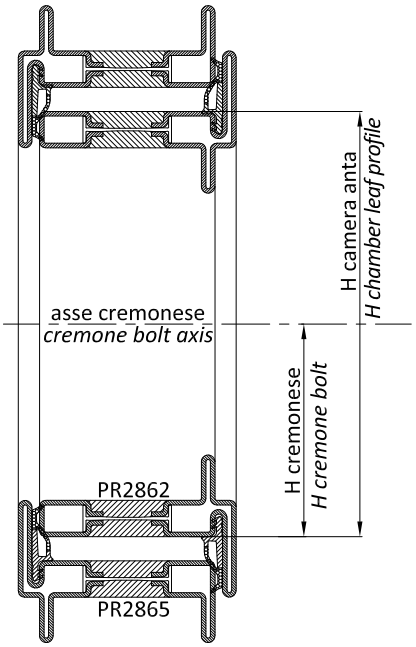
2) Insert the rods into the slits on the leaf corners

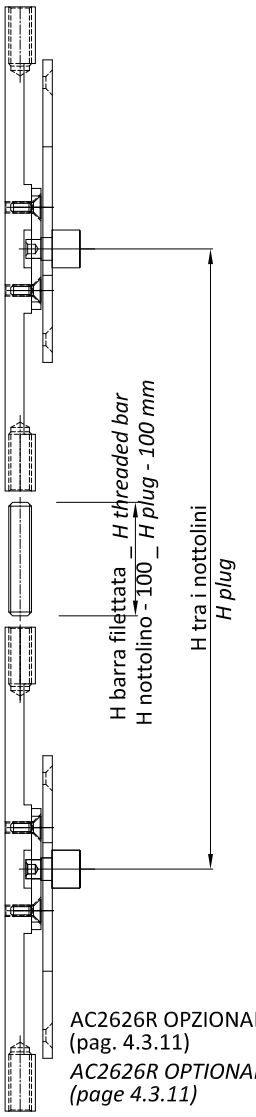
3) Insert the "GRATZ" mechanism into the leaf and secure

4) Secure the closing rods to the "GRATZ" mechanism using the M4 screws

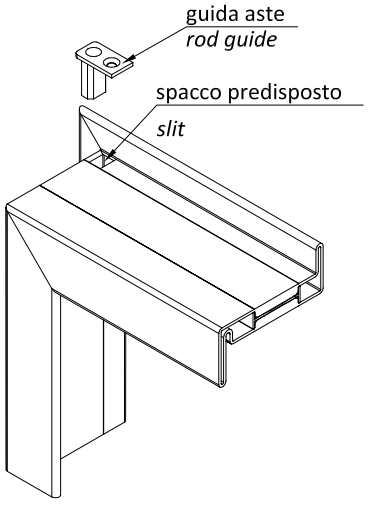
5) Insert the rod guides into the slits and fix them to the leaf

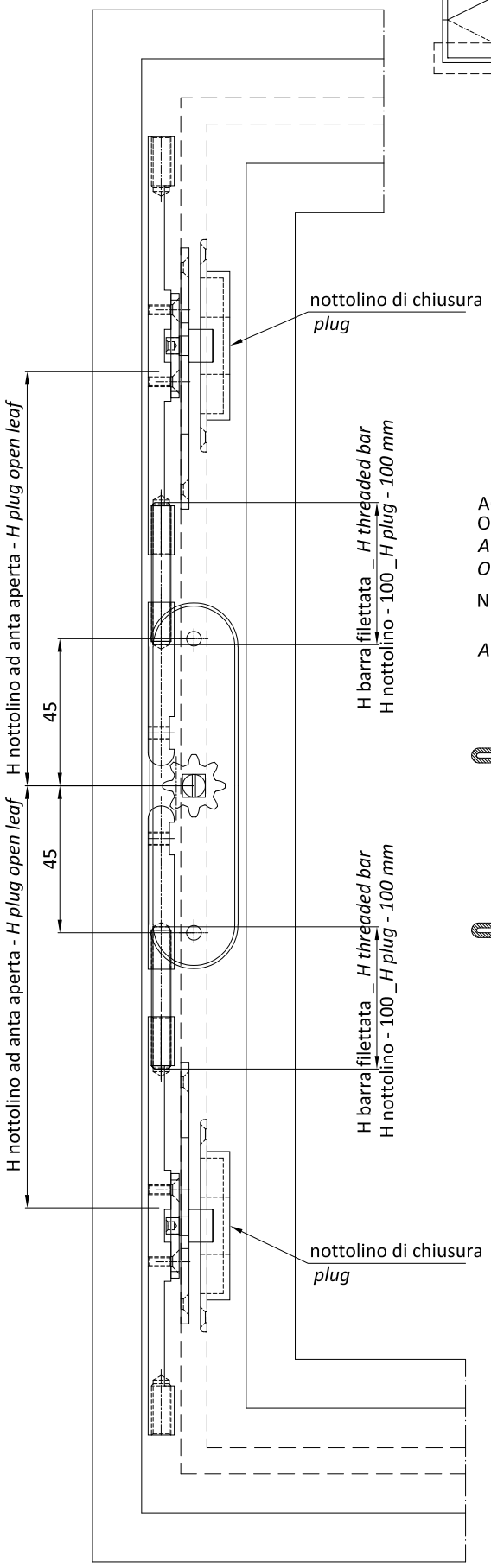
6) Secure the fittings to the frame

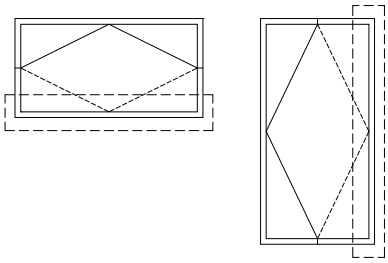


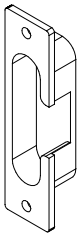


AC2626R OPZIONALE
(pag. 4.3.11)
AC2626R OPTIONAL
(page 4.3.11)





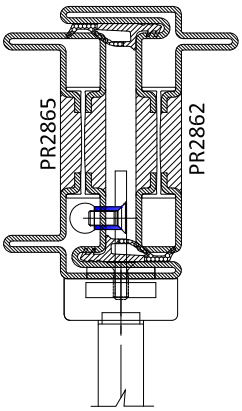


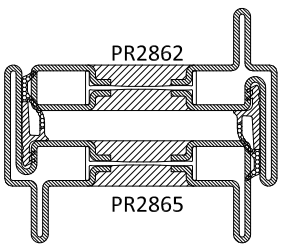


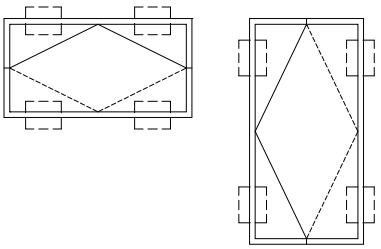
AC2626R incontro 3^ chiusura
OPZIONALE
AC2626R 3rd lock strike plate
OPTIONAL

N.B. prevedere un punto di chiusura ogni 1000 mm max.

Attn. Consider one locking point every 1000 mm max

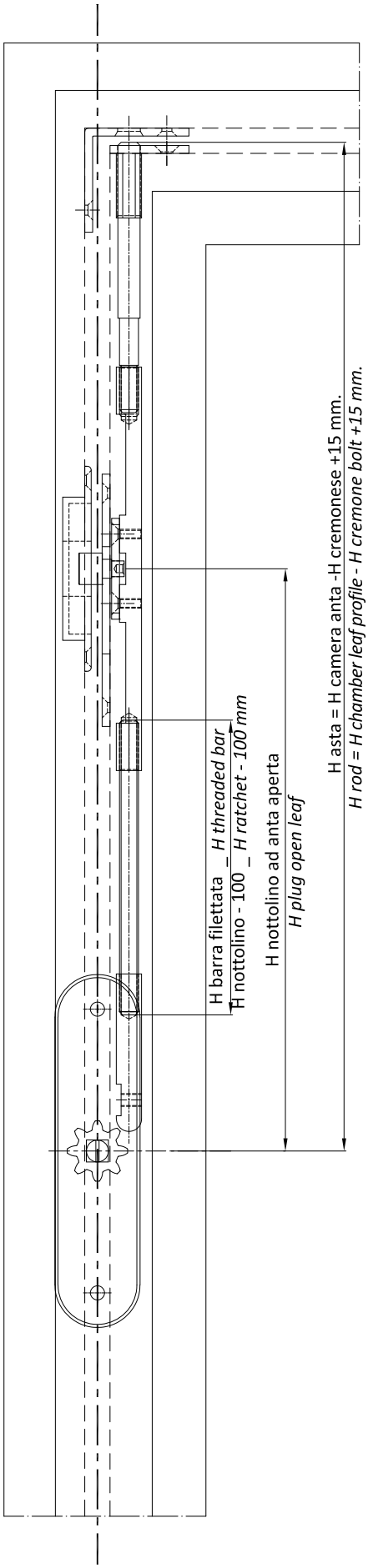


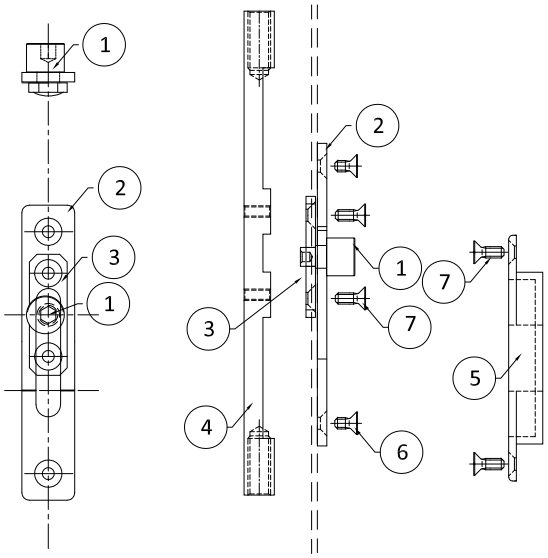


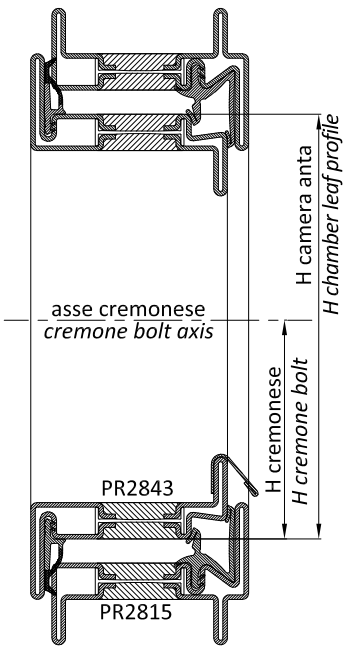


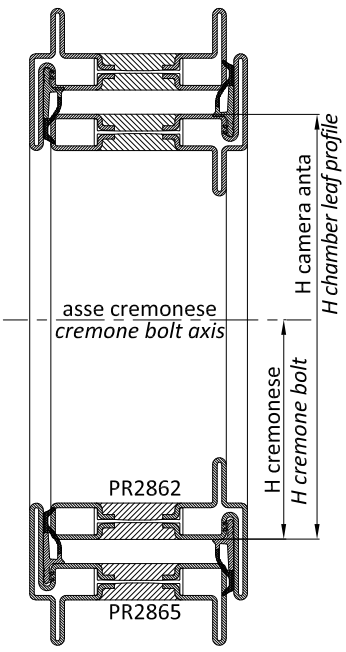
1) Rullino eccentrico
2) Piastra di fissaggio
3) Piastra di collegamento
4) Accessorio aggancio aste
5) Incontro 3^ chiusura
6) viti M3 x 6
7) viti M3 x 8

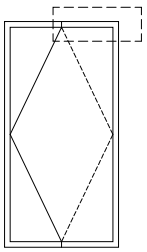
1) Barrel cam
2) Installation plate
3) Connecting plate
4) Rod docking accessory
5) 3rd lock strike plate
6) screws M3 x 6
7) screws M3 x 8

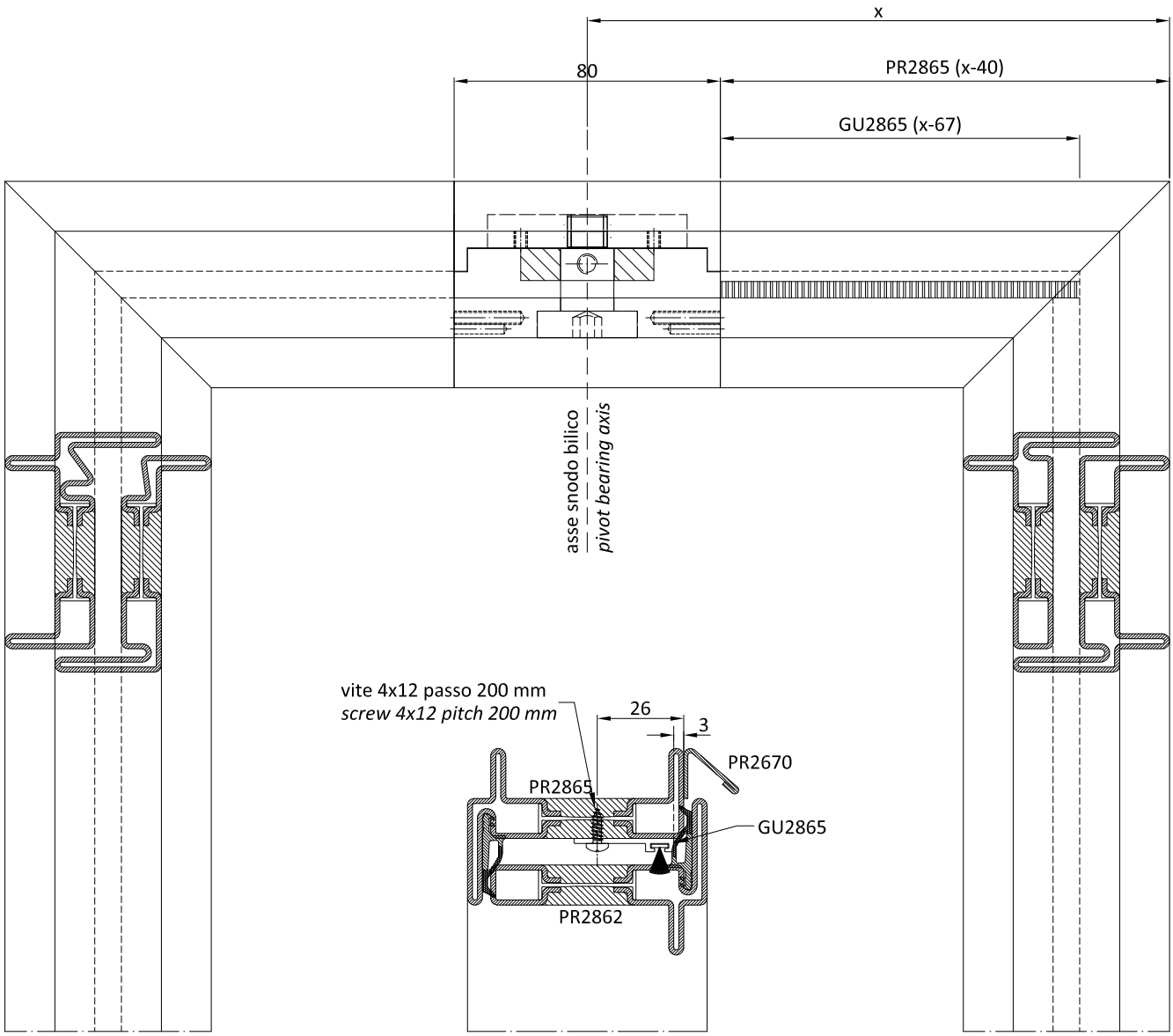




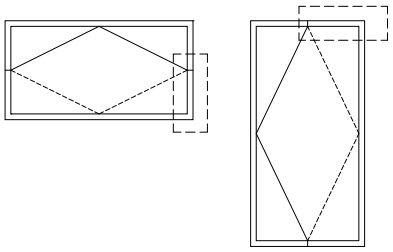


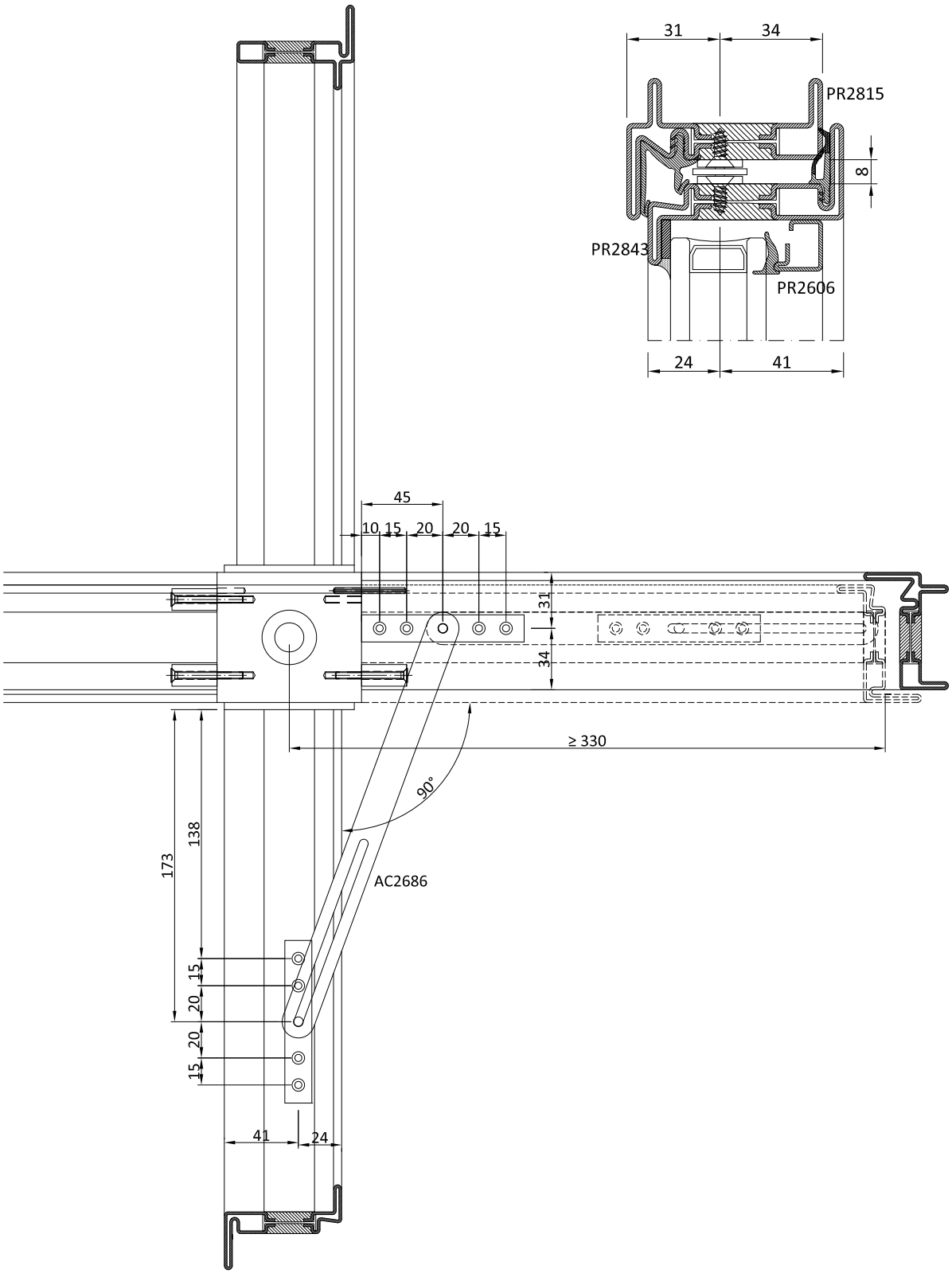


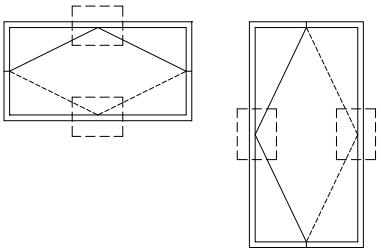


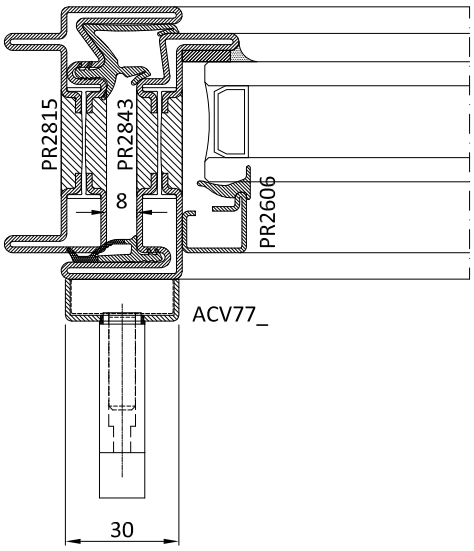


* vite 4x12 mm non comprese | *screw 4x12 mm not supplied*




31
34
PR2815
8
PR2843
PR2606
24
41
45
10 15 20 20 15
31
34
≥ 330
90°
AC2686
173
138
15
20
20
15
41
24

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PR2606
ACV77_
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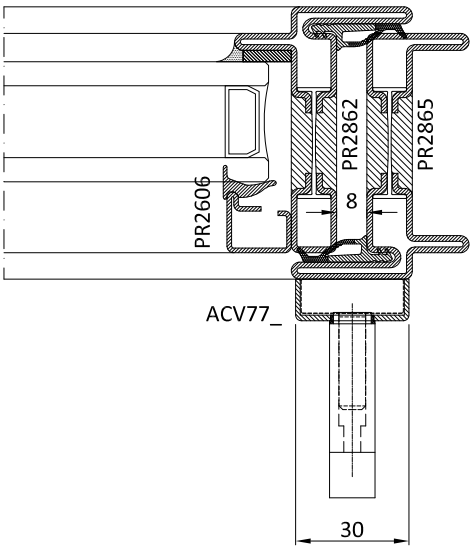
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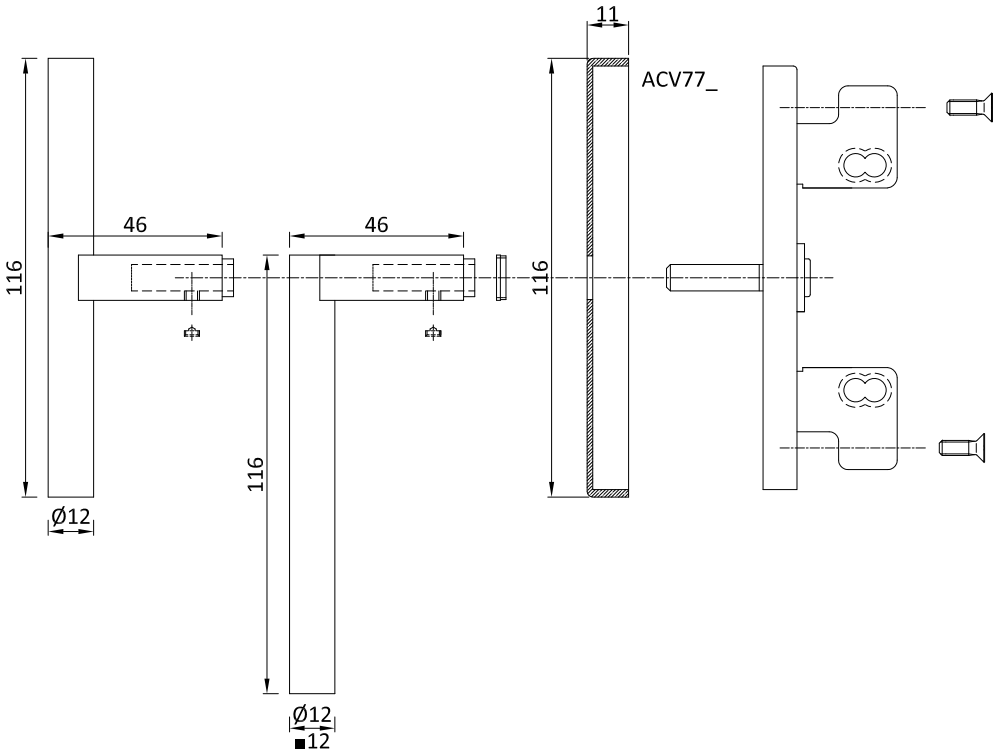
ACV77_
30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ACV77_
46
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Ø12
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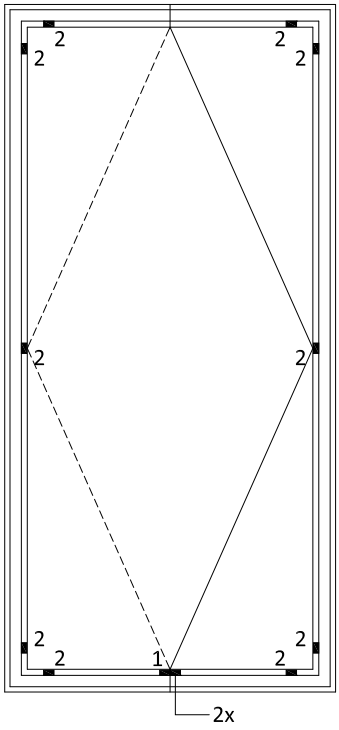
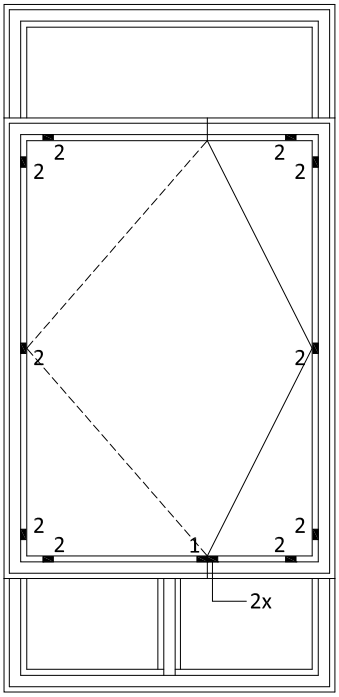
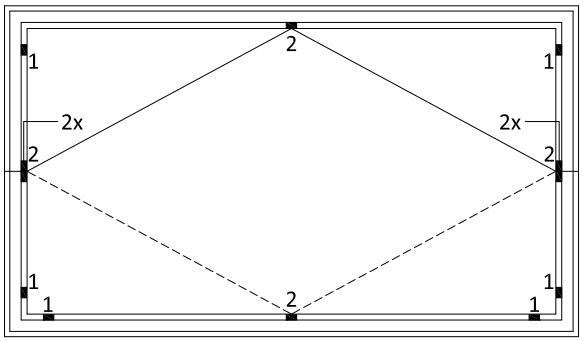
■12

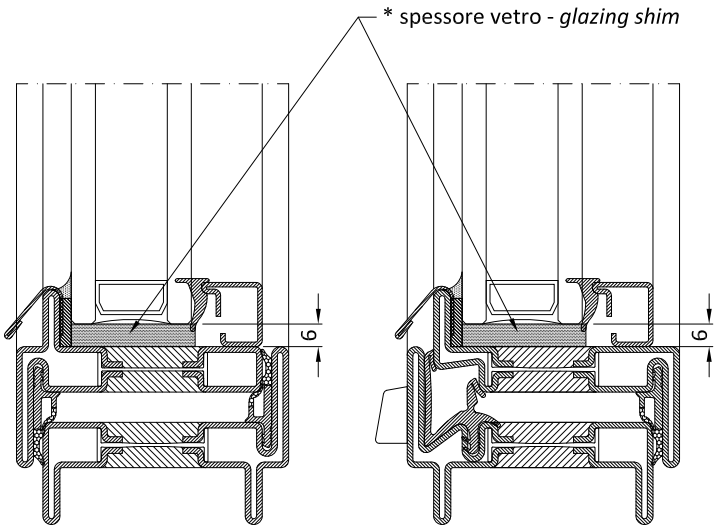


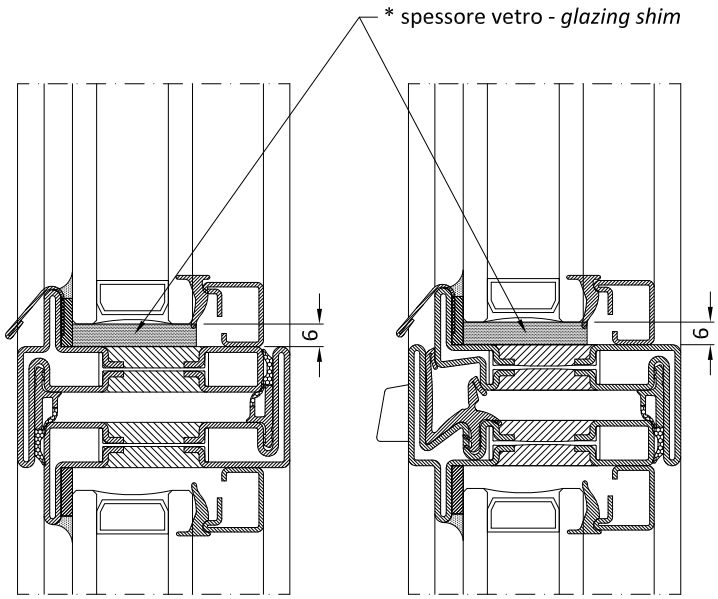




1) spessore portante | *carry shim*

2) spessore distanziatore | *compensation shim*





Note / *Note*

- La larghezza degli spessori è almeno pari o maggiore (+2 mm) dello spessore del vetro installato.
- *The shims width is the same or bigger (+2 mm) than the installed glas spacer.*

- La posizione degli spessori deve essere garantita dall'utilizzo di materiale adeguato che ne eviti la migrazione.
- *The shims position has to be provided by using an appropriate material which avoids any movements.*

* spessori vetro non inclusi - *glazing shims not supplied*

Generalità
I sistemi progettati e sviluppati dalla Secco Sistemi sono idonei per la fabbricazione di un'ampia gamma serramenti, vetrate e facciate in metallo. I sistemi sono rivolti ad aziende esperte e professionali nel campo della lavorazione dei metalli e della costruzione di serramenti e facciate, che sono a conoscenza delle normative di riferimento, delle direttive e delle specifiche tecniche del fornitore del sistema, nonché delle fondamentali regole dell'arte per la produzione e installazione di questi manufatti. Tutta la documentazione tecnica fornita costituisce un riferimento per i tecnici qualificati delle aziende al fine di indicare le modalità per la costruzione dei prodotti. In ogni caso i tecnici qualificati devono analizzare criticamente le indicazioni riportate per verificarne la loro adeguatezza per ogni singola commessa in relazione ai carichi, agli stress previsti e alle condizioni di messa in opera, essendo impossibile riportare in questa documentazione tutte le varianti riscontrabili nei progetti reali.

Tolleranze
OS2 65 è composto da una serie di profili dalle ridottissime dimensioni e prevede un accoppiamento dei telai esterni con le ante apribili con distanza di 8 mm. Per garantire il corretto funzionamento degli accessori e delle guarnizioni le lavorazioni devono essere eseguite con particolare attenzione e precisione: si consiglia di mantenere la tolleranza per la dimensione degli elementi apribili compresa tra +0/-1 mm e la tolleranza per il sormonto degli stessi compresa tra +0/+0.5 mm.

Taglio/Lavorazioni
I profili OS2 65 in acciaio, acciaio inox e corten possono essere tagliati con le normali troncatrici a disco utilizzate per i tubolari in acciaio, mentre per il taglio dei profili in ottone possono anche essere utilizzate troncatrici utilizzate per le serie di alluminio. Vista la loro particolare dimensione e forma si consiglia di utilizzare le ganasce di taglio previste dal sistema (AT2800) per assicurare una perfetta stabilità dei profili durante il taglio. La verifica del taglio sia per la sezione inclinata a 45° che per la sezione verticale a 90° dovrebbe garantire una tolleranza compresa tra -1°/+1°. Tutte le lavorazioni devono essere eseguite con il rispetto della seguente nota tecnica ed eventuali modifiche concordate con l'ufficio tecnico Secco Sistemi.

Saldatura
I profili OS2 65 possono essere saldati con i tradizionali sistemi di saldatura (MIG/MAG, TIG), con un idoneo sistema di lubrificazione/refrigerazione e utilizzando le istruzioni presenti nella presente nota tecnica ed evitando di saldare in prossimità della giunzione a taglio termico. L'eventuale riscaldamento del poliuretano libera sostanze gassose a base di aldeidi e CO: per tale ragione si consiglia di saldare con gli appositi DPI previsti e in zone con sufficiente areazione e in presenza di sistema per l'evacuazione dei fumi. I profili in corten devono essere saldati con apposito filo in corten mentre per i profili in ottone si può utilizzare un filo CuSi3. Si raccomanda di saldare in profondità e senza lasciare fori e porosità le aree in contatto, di lisciare e pulire adeguatamente la superficie saldata per garantire una corretta resistenza strutturale all'angolo e permettere una successiva verniciatura senza imperfezioni estetiche visibili (pori e ondulazioni).

Verniciatura/Brunitura
I profili OS2 65 sono stati progettati per essere verniciati a polveri in forni con temperature di 180°C per 25 minuti. La zona a taglio termico in poliuretano non è in grado di accogliere con sufficiente adesione le polveri poliesteri e perciò si consiglia di ricoprire tali zone, nelle sole parti destinate ad essere in vista, con apposite pellicole adesive idonee al passaggio in forno (SA1024/33/42/52). I telai prima della verniciatura o della brunitura devono essere forati come da istruzioni presenti in questa nota tecnica per permettere la fuoriuscita dei liquidi utilizzati durante il pretrattamento delle superfici. All'uscita del forno di polimerizzazione della polvere i telai vanno rimossi accuratamente e adagiati in posizione piana sino al loro completo raffreddamento.
Si consiglia di seguire il ciclo di pretrattamenti e verniciatura presente nella documentazione Secco Sistemi.

Vetrazione
Il sistema di fissaggio del vetro prevede l'utilizzo di fermavetri agganciati all'interno tramite clips o boccole interne e mandati in pressione con l'incastro dell'apposita guarnizione e all'esterno, l'utilizzo di siliconatura o inserimento della guarnizione adesiva GE2606 (il sistema con sigillatura è da utilizzarsi quando le ante superano 1 m^2 di superficie per garantire una maggior rigidità del pannello vetrato). Per il corretto funzionamento del sistema si suggerisce di verificare la perfetta compressione delle guarnizioni interne del fermavetro e la mancanza di imperfezioni lungo il perimetro della siliconatura esterna.

Installazione
La corretta installazione deve garantire il mantenimento delle performance dichiarate nella marcatura CE e testate in laboratorio. Si consiglia di progettare un corretto numero di fissaggi in relazione al tipo di controtelaio/muratura esistente e alle dimensioni degli elementi da installare. Al termine dell'istallazione si verifichi il corretto funzionamento del serramento (facilità di apertura/chiusura, stabilità dell'anta aperta a riposo, etc.), il rispetto delle fughe e del sormonto tra ante apribili e telai fissi, il regolare posizionamento delle guarnizioni e delle sigillature, il drenaggio del giunto aperto e la mancanza di difetti estetici sulle superfici del telai e del vetro.

General information
The systems designed and developed by Secco Sistemi are suitable for the manufacturing of a wide range of doors, windows and shutters, as well as faces or facades in metal. The systems are designed for professional and expert companies in the metal-working sector and that of construction of doors, windows, shutters and facades. These companies are well aware of the specific regulations and the directions and technical specifications of the system supplier, and also the fundamental rules of the art of manufacturing and installing these products. All the technical documentation provided furnishes a source of reference for the qualified technicians of the companies, giving indications as to how the products should be constructed. These qualified experts must critically analyse the indications to verify their adequacy for each single order in terms of load, stress and conditions of installation, particularly as this documentation cannot provide for all the different variations that may be found in projects.

Tolerance
OS2 65 is made of a series of very thin profiles. It provides coupling of external frames with opening leaves with a distance of 8 mm. To ensure the correct use of hardware and gaskets the processing must be performed with great care and precision. It is advised to keep the tolerance between +0/-1 mm for opening elements and between +0/+0.5 mm for their overlapping area.

Cut / Processing
OS2 65 profiles in steel, stainless steel and corten can be cut with normal saws, like the ones used for steel pipes. OS2 65 profiles in brass can be cut with saws used for aluminium. Given their dimension and size, it is recommended to use the cutting jaws provided with the system (AT2800) to ensure perfect stability during the cutting procedure. In order to verify the correctness of the cut, the tolerance of both the 45° and the 90° sections must be between -1°/+1°. Processing must be performed in line with this technical note and any variation agreed with Secco Sistemi's Technical Department.

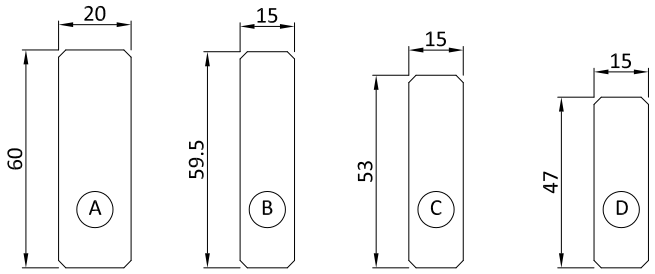
Welding
OS2 65 profiles can be welded with the traditional systems (MIG/MAG, TIG), with an appropriate lubricating/cooling system and according to the instructions as per this technical note. Avoid welding near the thermal break joint. Heating any polyurethane items releases gaseous substances containing aldehydes and CO. For this reason it is recommended to weld with the special DPIs provided and in areas with sufficient ventilation and with fumes disposing systems. The corten profiles must be welded with special corten wire, while for profiles in brass a CuSi3 wire can be used. It is recommended to weld in depth, to avoid leaving any holes or porosity on the surfaces and to smooth and clean the welded surface thoroughly. This is to guarantee a proper structural resistance at the corner and to allow for a later painting without any visible imperfections (pores and ripples).
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised

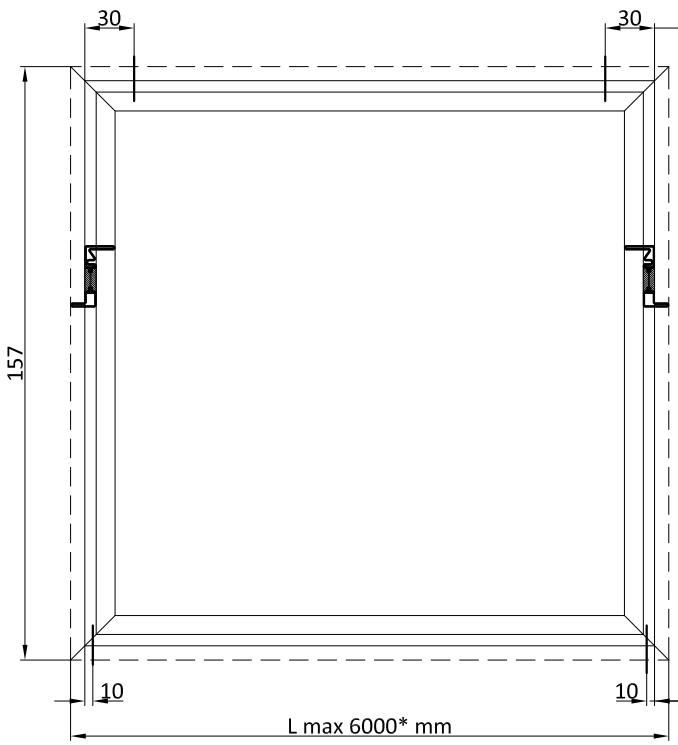
Painting/Burnishing
OS2 65 profiles have been designed to be painted with the powder coating technique in industrial ovens at temperatures of 180°C for 25 minutes. The thermal break area is not designed to absorb polyester powders and therefore it's advised to cover the visible areas with appropriate industrial-oven-resistant adhesive films (SA1024/33/42/52). Holes must be drilled (as per instructions) in the frames before painting or burnishing in order to allow drainage of any liquid used as a pre-treatment of the surfaces. Once out of the oven, the frames must be accurately removed and laid in a horizontal position until complete cooling.
It is advised to follow pre-treatment and painting cycles as outlined in Secco Sistemi documentation.

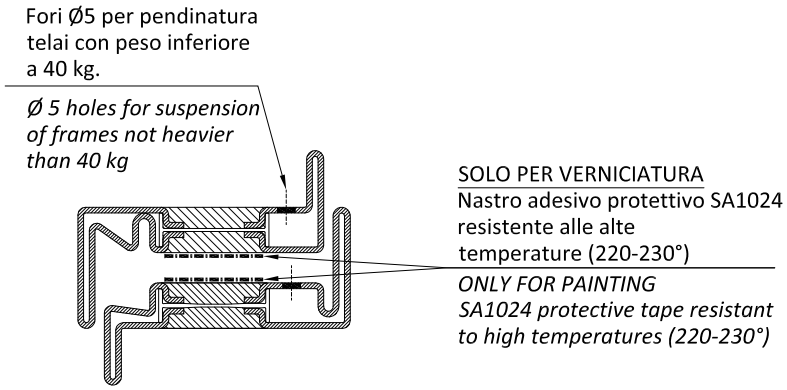
Glass application
Glass needs to be secured internally and externally. Internally, glass beads must be used together with clips or bushings and then secured by pressure with the appropriate gasket. Externally, glass must be secured by applying silicone or adhesive gasket GE2606 (the latter is recommended when leaves dimensions are bigger than 1 square metre in order to guarantee a higher rigidity of the glass). In order to ensure the correct behaviour of the system, it is recommended to verify the proper pressurization of the internal glass bead gaskets and that the external silicone perimeter is completely free of imperfections.

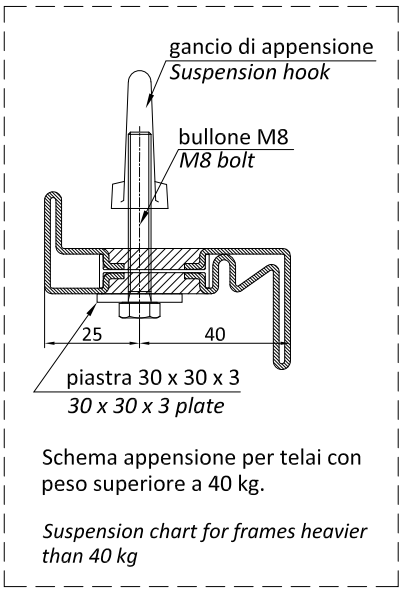
Set up
The proper set up must guarantee that the performance in the CE marking and verified in the lab will remain constant. It is advised to design a correct series of set ups with reference to the existing type of subframe/brickwork and to the dimensions of the elements to set up. Once the set up is finished, you should verify the proper behaviour of the window/door (easiness of opening/closing, stability of the open leaf, etc.), the correctness of joints and overlapping areas between opening leaves and fixed frames, the proper positioning of gaskets and seals, the drainage of frames with weep system and the absence of any aesthetic defects on the frame and glass surfaces.


A
PR2801
B A
PR2803
D A
PR2815
C A
PR2842
B A
PR2843
A
PR2861
C A
PR2862
B A
PR2863
D A
PR2865
C
PR2871
C C
PR2872
C C
PR2873
C D
PR2874
B A
PR2875
C C
PR2664
B B
PR2891
B B
PR2892
B B
PR2893
B D
PR2895


20
60
A
15
59.5
B
15
53
C
15
47
D

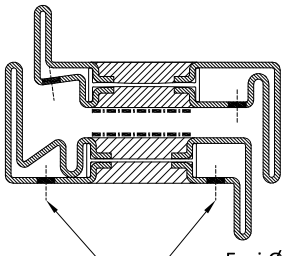






Schema appensione per telai con peso superiore a 40 kg.

Suspension chart for frames heavier than 40 kg



Fori Ø 8 per lo scarico del liquido di lavaggio

Ø 8 holes for washing liquid evacuation

SOLO PER BRUNITURA

Preparare il profilo da trattare pulendolo con una paglietta tipo Scotch Brite in modo da ottenere superfici lucide e uniformi.

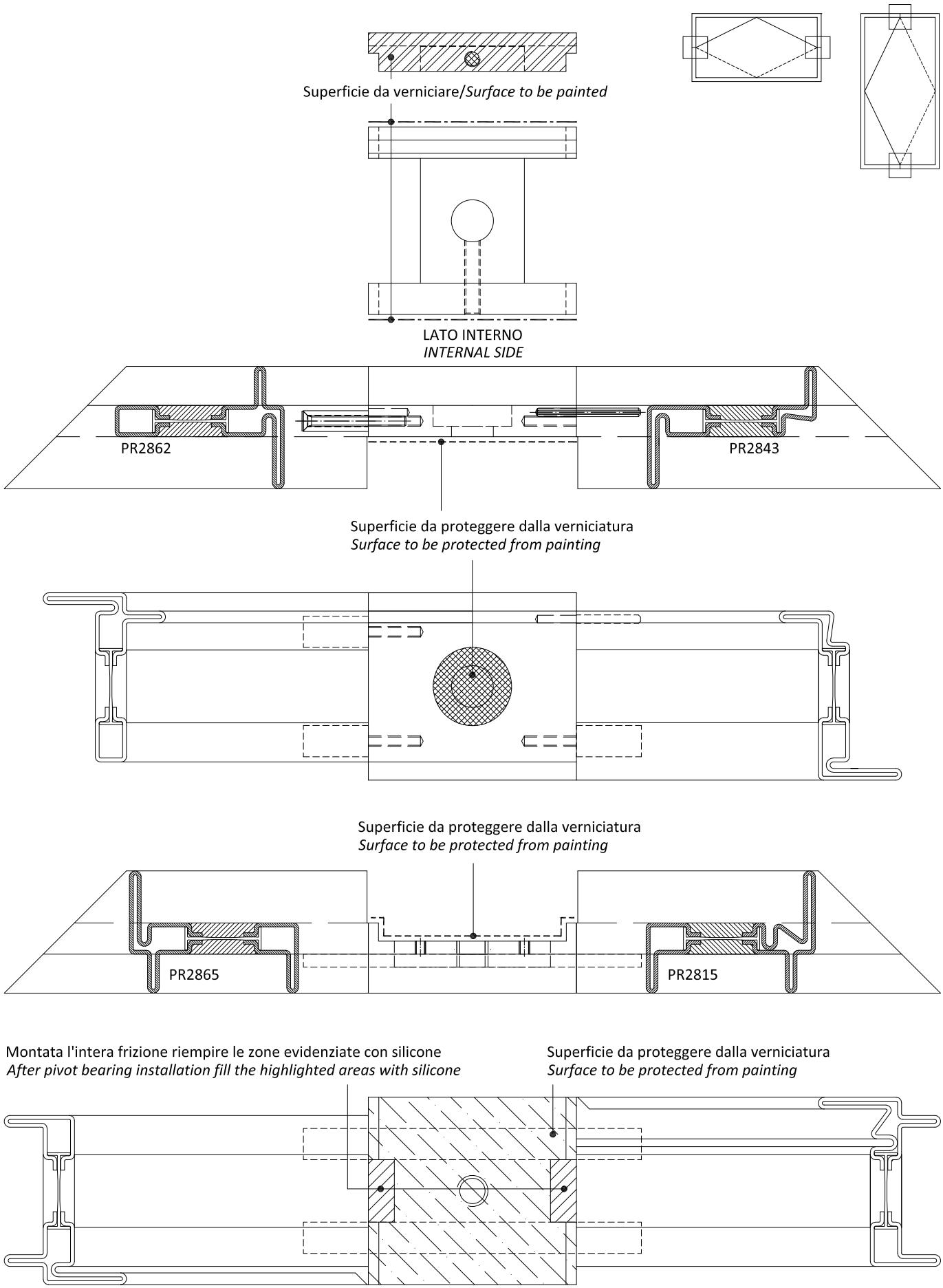
Movimentare il prodotto carteggiato con cautela per non danneggiare la finitura superficiale e non toccare a mani nude il profilo per ottenere un trattamento di brunitura uniforme.

ONLY FOR BURNISHING

Prepare the profile grinding it with a Scotch Brite wool in order to obtain uniform surfaces.

Ease profiles carefully to avoid any damages on the surface as well as do not touch it with hands to allow an uniform burnishing.

* Dimensioni massime disponibili nell'impianto di Secco Sistemi
Maximum available size in the Secco Sistemi plant


Superficie da verniciare/*Surface to be painted*
LATO INTERNO
INTERNAL SIDE
PR2862
PR2843
Superficie da proteggere dalla verniciatura
Surface to be protected from painting
Superficie da proteggere dalla verniciatura
Surface to be protected from painting
PR2865
PR2815
Montata l'intera frizione riempire le zone evidenziate con silicone
After pivot bearing installation fill the highlighted areas with silicone
Superficie da proteggere dalla verniciatura
Surface to be protected from painting

Troncatrice

caratteristiche minime della macchina

- Potenza: 1.8 – 2.5 kW;
- Possibilità di taglio a 45° nei due sensi e a 90°;
- Velocità di taglio ideali: 15-30 giri/min per acciaio inox;
  60-90 giri/min per acciaio zincato e corten,
  90 giri/min o superiori per bronzo (OT/67);
- Capacita di taglio: 150 x 80 mm a 90°;
  100 mm taglio a 45°.

caratteristiche della lama

- Lama da 350 mm con spessore 2.5 mm;
- N° denti: - 300 per tagli a 45°;
  - 350 per tagli a 90°;
- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle lame).

NB: è possibile tagliare la lega OT/67 con le stesse macchine dell'alluminio.

Pantografo

caratteristiche minime della macchina

- Mandrino con velocità regolabile 2000-11000 giri/min (per un corretta lavorazione su acciaio inox è necessario operare a n° ridotto di giri < 4000);
- Struttura in ghisa adatta al taglio acciaio;
- Testata pesante per limitare le vibrazioni;
- Chiusura del profilo da lavorare con morse.

caratteristiche minime delle frese

- Materiale: HSS (verificare materiali di commercio con finiture che migliorano la durata delle frese);
- Frese a 4 denti;
- Frese con diametro 5 mm per le lavorazioni di scasso.

Forature

montaggio componenti di chiusura e movimentazione sui profilati in acciaio inox

- Forare con punte da trapano HSS del diametro indicato sulla corrispondente tavola tecnica;
- Maschiare il foro con vite autofilettante zinco-cromata avente diametro corrispondente alla vite inox fornita nel kit con l'articolo da montare;
- Posizionamento e fissaggio definitivo dell'articolo con le viti inox in dotazione.

fresatura di cave e asole sui profili inox

- Adoperare macchine (pantografi o fresatrici) adeguate alle lavorazioni dell'acciaio;
- Regolazione del numero di giri max (3000 giri/1');
- Impiego di frese di diametro massimo di 8 mm a 4 pale in acciaio HSS;
- Abbondare con la lubrificazione, concentrata sull'utensile;
- Ridurre l'avanzamento fino ad accertare un taglio il più regolare possibile;
- È normale un'usura accelerata dell'utensile.

Cutter

Minimum requirements for the use of the machine

- Power: 1.8 – 2.5 kW;
- Possibility of cutting at 45° in both directions and at 90°;
- Ideal cutting speed: 15-30 rmp for stainless steel;
  60-90 rmp for galvanised and corten steel;
  90 rmp or higher for bronze (OT/67);
- Cutting capability: 150 x 80 mm at 90°;
  100 mm cut at 45°.

Blade specifications

- 350 mm blade with a 2.5 mm thickness;
- Number of teeth: 300 for 45° cut;
  350 for 90° cut;
- Material: HSS (please verify availability of longer lasting material on the market).

Note: OT/67 alloy can be cut with machines made for aluminum.

Phantograph

Minimum requirements for the use of the machine

- Mandrel with a 2000-11000 rmp adjustable speed (for a proper stainless steel processing a slower speed is required i.e.<4000 rpm);
- Machine should be made of cast iron suitable for steel cutting;
- Heavy head in order to limit vibrations;
- Secure the profile to be processed in jaws.

Minimum requirements for the use of a milling machine

- Material: HSS (please verify availability of longer lasting material on the market);
- Use a 4-tooth milling machine;
- Use a milling machine with a 5-mm diameter for groove processing.

Drilling

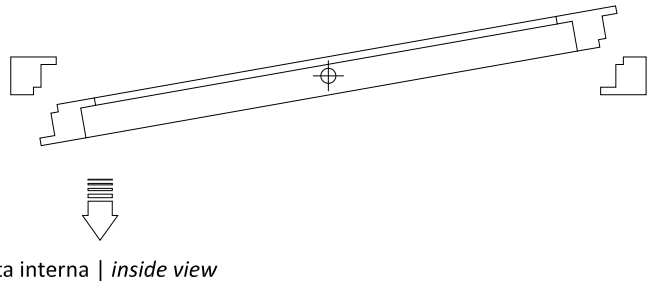
How to mount closing and moving components on a stainless steel profile

- Use a HSS drill. The diameter of the drill is indicated in the technical note;
- Thread the hole with self-threading zinc-plated screws with the same diameter as the stainless steel screw provided with the kit;
- Position and secure the item with the stainless steel screws provided.

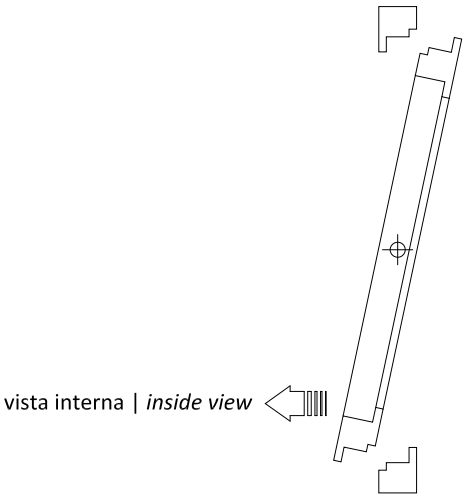
Milling slots and loops in the profiles

- Use machines designed for steel processing (pantographs or milling machines);
- Max rpm setting (3000 rpm);
- Use milling machines with a diameter no bigger than 8 mm and with 4 HSS steel blades;
- Exceed with lubrication, mainly on the machine;
- Processed slowly until the milling is as clean as possible;
- Expect a fast wearing of the machine.

APERTURA A BILICO | *PIVOTING WINDOW OPENING*

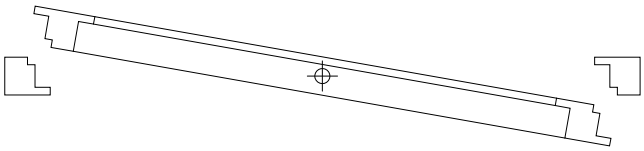


vista interna | *inside view*

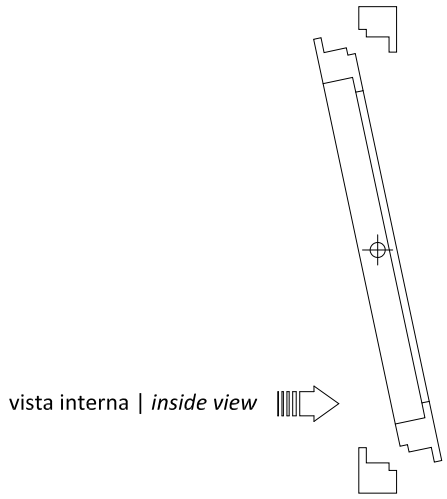


vista interna | *inside view*

Kit cremonese | *Cremone bolt*	
apertura interna | *inwards openings*	apertura esterna | *outwards openings*
AC 2625 D	AC 2683 S



vista interna | *inside view*



vista interna | *inside view*

Kit cremonese | *Cremone bolt*	
apertura esterna | *outwards openings*	apertura interna | *inwards openings*
AC 2683 D	AC 2625 S

1. Controllo materiale in arrivo / *Incoming equipment Control*

Verifica visiva dell'intergrità delle barre con attenzione a: / *Profiles wholeness visual control paying attention to:*

- Strisci profondi / *Deep scratches* — verifica visiva / *visual control*
- Botte e avvallamenti sulla superficie / *Bumps and dips on surface* — verifica visiva / *visual control*
- Rettilineità barre / *Profiles straightness tolerance* — 0,002 x L
- Svergolamento / *Profiles twist tolerance* — 1° x m

2. Taglio barre e controllo barre / *Cut and Control of profiles*

- Misura lunghezza / *Length measurement* — ±0.5 mm
- Verifica 45° / *45° Control* — ± 1°
- Verifica 90° / *90° Control* — ± 1°

3. Lavorazioni su barra / *Section processing*

Finestra bilico/ *Pivoting window*	Apertura interna / *Inward opening*	Apertura esterna / *Outward opening*
Fori e asole per cremonese *Espagnolette holes*	AC2625 sez 4.3.7	AC2683 sez 4.3.8-9
Fori e asole per chiusura supplementare *Additional locking points slots and holes*	AC2626R sez 4.3.10	AC2626R sez 4.3.11
Lavorazione snodo bilico *Pivot bearing working*	AC2633/37/38 sez 4.3.12-15	AC2633/37/38 sez 4.3.12-15
Fori per scarico acqua *Water drip holes*	AC2618 sez 4.3.4	
Fori limitatori apertura *Restrictor stays holes*		AC2687 sez 4.3.42-44
Fresature per limitatori sporgere *Stay arm for awning windows milling*	- -	AC2690 sez 4.3.47
Lavorazione gocciolatoio *Water drip section workink*	P.2620 sez 4.3.5	P.2670 sez 4.3.6
Fori fissaggio a muro *Wall mounting holes*	sez 3.3.1-5	sez 3.3.1-5

4. Assiemaggio / *Assembly*

Finestra bilico/ *Pivoting window*	Apertura interna / *Inward opening*	Apertura esterna / *Outward opening*
<u>Costruzione telai</u>		
Inserimento squadrette (profili ottone) – Saldatura / *Brackets insertion (brass section) - Welding*	AC28xx sez 4.4.1-2	AC28xx sez 4.4.1-2
Sigillatura interna della giunzione (ottone) *Internal joint sealing (brass sections)*	AC28xx sez 4.4.1-2	AC28xx sez 4.4.1-2
<u>Applicazione accessori</u>		
Assiemaggio snodo bilico *Assembling pivot bearing*	AC2633/37/38 sez 4.4.6-18	AC2633/37/38 sez 4.4.6-18
Fori limitatori apertura *Restrictor stays holes*		AC2686 sez 4.5.8

5. Preparazione per verniciatura - brunitura /*Preparation for the powder coating - burnishing*
   a. Fori su telaio per scarichi liquidi pretrattamento — sez 5.1.4
      Holes on frame for the drainage of pretreatment liquid
   b. Marcatura e imballo telai esterni e ante — -
      External frames and leafs branding and packing
   c. Marcatura e imballo telai fermavetro — -
      Glazingbeads frames branding and packing
   d. Marcatura e imballo profili complementari — -
      Additional profiles branding and packing
   e. Imballo scarichi acqua e cerniere — -
      Accessories (water drip, hinges) branding and packing

6. Applicazione accessori e sigillatura / *Hardware and accessories installation and sealing*
   a. Finestra bilico / *Pivoting window*
      I. Applicazione e sigillatura guarnizioni giunto aperto / — sez 4.5.1
         Sealing of central gasket
      II. Applicazione scarichi acqua / *water drip installation* — sez 4.5.1
      III. Montaggio snodo bilico — sez 4.4.17-18
         Pivot bearing installation
      IV. Montaggio cremonese e incontri / *Espagnolette installion* — sez 4.5.2-7
      V. Montaggio guarnizioni di battuta / *Gasket installation*
      VI. Sigillatura angolo nel TT / *Corner joint sealing*

7. Vetrazione / *Glazing*
   a. Applicazione clips fermavetro / *glazing bead clips installation* — sez 2.8.1-8
   b. Applicazione guarnizione esterna / *External glazing gasket installation*
   c. Applicazione vetro (spessoramento) / *Glazing installation (setting blocks)* — sez 4.6.1
   d. Inserimento fermavetri / *Glazing beads application*
   e. Inserimento guarnizione interna fermavetro / *Fit glazing bead to glass gasket*
   f. Verifica corretta compressione guarnizione /
      Control of the right compression of the gasket

8. Controlli su prodotto finito / *Control on finished element*
   a. Verifica distanza tra anta e telaio / — +0 +0.5 mm
      Control of gap between leaf and frame
   b. Verifica sormonto anta su telaio / *Control of leaf surmount* — +0 +1 mm
   c. Verifica sigillature per scarico acqua / — test con acqua su giunto
      Control of central gasket sealing — *test with water*
   d. Verifica funzionamento cremonese/maniglia serratura
      Control of hardware functioning
   e. Verifica finitura superficiale / *Control of surface finishing*

9. Controlli dopo la posa / *Controls after installation*
   a. Verifica corretta installazione telai: squadra, piombo, misure /
      Control of alignment and plulmbing of frame and leaf
   b. Verifica distanza tra anta e telaio / — +0 +0.5 mm
      Control of gap between leaf and frame
   c. Verifica sormonto anta su telaio / *Control of leaf surmount* — +0 +1 mm
   d. Verifica sigillature per scarico acqua / — test con acqua su giunto
      Control of central gasket sealing — *test with water*
   e. Verifica funzionamento cremonese/maniglia serratura
      Control of hardware functioning
   f. Verifica finitura superficiale / *Control of surface finishing*

MATERIALI

ACCIAIO INOX
Materiale
Profilati ricavati da nastro di lamiera di acciaio inox laminato a freddo pre-trattato industrialmente per garantire la massima qualità e uniformità.
Caratteristiche fisiche
AISI 316L Marino (X2 CrNiMo 17-12-2)
Norme di riferimento
EN 10088-2; EU 114
Trattamenti superficiali
Finitura Scotch Brite: ottenuta su nastro AISI 316L (marino) con finitura superficiale 2B con successiva spazzolatura Scoth Brite.

ACCIAIO COR-TEN
Materiale
Profilati ottenuti da nastro in acciaio altoresistenziale, autopassivante (che un tempo veniva commercializzato con il nome Cor-Ten) tale da formare, se esposto all'aria, uno strato di ossido uniforme e stabile che, ricoprendo la lamiera, ne arresta la corrosione atmosferica.
Caratteristiche fisiche
Fe 510 X (C max % 0,12: Si % 0,25-0,75: Mn % 0,20-0,50: P % 0,07-0,15: Cu % 0,25-0,55: Cr % 0,30-1,25: Ni max % 0,65)
Norme di riferimento
EN 10149
Trattamenti superficiali
Dopo la profilatura il materiale viene immerso in speciali bagni ossidanti tali da accelerare la formazione dello strato protettivo. Raggiunta la tonalità desiderata della superficie si procede ad una ceratura di stabilizzazione del materiale.

ACCIAIO ZINCATO VERNICIATO
Materiale
Profilati ottenuti da nastro in lamiera di acciaio zincato a caldo sistema Sendzimir finitura skinpassata
Caratteristiche fisiche
FeP02 GZ 200 (copertura di zinco pari a 200gr/m^2 per faccia)
Norme di riferimento
UNI EN 10142/3/7; EURONORM 143
Trattamenti superficiali per la verniciatura
La preparazione del supporto zincato si effettua tramite i processi di sgrassaggio, decapaggio e lavaggio in acqua. Segue l'applicazione di uno strato di zinco per fosfatazione seguito da lavaggi in acqua demineralizzata. Infine applicazione della mano a finire con polveri poliestere cotte in forno a 180 °C per 25 minuti.

LEGA DI RAME OT67
Materiale
Profilati ottenuti da nastro di Lega di Rame OT67 laminato a freddo rincrudito allo stato grezzo.
Caratteristiche fisiche
Cu Zn 33 CW 506L (OT 67, 67% rame e 33% zinco)
Norme di riferimento
EN 1652:1999
Trattamenti superficiali
Finitura brunita: dopo la profilatura viene eseguita una ricottura di distensione, quindi la pulitura meccanica con abrasivo e la successiva brunitura per immersione con liquido brunitore; il profilo viene poi lavato e asciugato ed infine protetto mediante trattamento con olio di vaselina.
Finitura lucida: dopo la profilatura viene eseguita una ricottura di distensione e successivamente la lucidatura a specchio.

MATERIALS

STAINLESS STEEL
Materials
Sections processed out of the cold-rolled coils, industrially pre-treated for utmost quality and uniformity.
Physical features
AISI 316L Marino (X2 CrNiMo 17-12-2)
Norms of reference
EN 10088-2; EU 114
Surface treatment
Scotch Brite: obtained on AISI 316L (marine) coil 2B pre-finish with Scotch-Brite post-scrubbing.

CORTEN STEEL
Materials
Sections processed out of highly resistant self-oxidising steel coils – once traded under the name Cor-Ten. If exposed to the open air, it produces a uniform protective layer that reduces weather corrosion.
Physical features
Fe 510 X (C max % 0,12: Si % 0,25-0,75: Mn % 0,20-0,50: P % 0,07-0,15: Cu % 0,25-0,55: Cr % 0,30-1,25: Ni max % 0,65)
Norms of reference
EN 10149
Surface treatment
After forming, sections are plunged into a special oxydising bath to catalyze formation of the protective coating. Once the desired tone obtained, sections are stabilized by a wax coating.

GALVANIZED AND PAINTED STEEL
Materials
Sections processed out of hot galvanized steel coils, band "Sendzimir, skinpassed finishing.
Physical features
FeP02 GZ 200 (*with zinc coating of 200 gr/sq x m on both faces*)
Norms of reference
UNI EN 10142/3/7; EURONORM 143
Pre-painted surface treatment
The preparation of a galvanised surface in made through several processes: degreasing, pickling an washing. A coating of zinc is then applied through a phosphatising process followed by rinses in demineralised water. A final coat in then applied with polyester powders baked at 180 °C for 25 minutes.

COPPER ALLOY OT67
Materials
Sections processed out of copper alloy coils, industrially cold-rolled.
Physical features
Cu Zn 33 CW 506L (OT 67, 67% *copper* and 33% *zinc*)
Norms of reference
EN 1652:1999
Surface treatment
Burnished finish: after forming, the product is submitted to stress relieving, then to mechanical cleaning with abrasive products and ultimately to burnishing by plunging into a burnishing solution. It is then washed and dried and protected with a vaseline coating.
Glossy finish: after forming, the product is submitted to stress relieveing and then mirror-like polished.

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